

ATLAS 261 SERIES FOLDER



PARTS CATALOG

September 2018

WebPress
Revolutionary.

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THIS DOCUMENT WAS INTENDED TO BE A DOUBLE SIDED DOCUMENT,
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THANK YOU
WEB PRESS ENGINEERING DEPARTMENT

REVISION HISTORY

REVISION	DESCRIPTION OF CHANGES	RELEASED	PAGES
SEPT 2005	1.UPDATE ALL PARTS LISTS TO REFLECT CURRENT BUILD 2. RE-VAMP ASSEMBLY DRAWINGS TO REFLECT CURRENT PARTS LISTS 3. ADDED REFERENCE ONLY STATEMENT TO ALL DRAWINGS	9/1/05	ALL

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Headroll Stand Assembly

**ATLAS FOLDER
HEADROLL STAND ASSEMBLY 2611001**

PART NO.	DESCRIPTION	QTY. REQ'D
001001	BALL BEARING, ER-16, 1"ID X 2.0742"OD, LOW DRAG	4
001054	BALL BEARING, ER-16X, LOW DRAG, (WEB GUIDE APPLICATION ONLY)	23
021028	COMPRESSION SPRING, 1" O.D. X 1" LONG (BLUE)	6
032003	SET COLLAR, 1"ID X 1-5/8"OD	7
032006	SET COLLAR, 1-1/4"ID X 2"OD	2
033001	KNOB, 1-3/8 OD X 3/8-16	3
033003	HANDLE, 3-1/8 DIA 1/2-13	7
035005	SCREW, THUMB, THREADED, 1/2-13 X 3-1/2 LG	1
060034	TIMING BELT, 1/2P X 2W X 125" LONG	1
061034	PULLEY, TIMING BELT, 36T X 1/2P X 2"W WITH TAPER BUSHING	2
062003	TAPER BUSHING, 1" BORE	2
067022	GEAR BOX, RATIO 1:1; STYLE CF, MLD 11, SPIRAL (LONG SHAFT)	1
069003	IDLER PULLEY, 4" DIAMETER GROOVE, 1" HOLE	1
069020	IDLER PULLEY, 1"BORE X 2" W X 1/2"P X 3-1/8" SL	1
090004	SLITTER WHEEL WITH BEARING, 1-5/16"ID X 2-5/8" OD	1
511260	LEVELING BOLT	4
511480	STIFFENER SHAFT	8
511490	ROLLER CORE	8
521460	STIFFENER	1
611150	HEAD ROLL	2
611230	BRACKET, TROLLEY CLAMP	6
611240	SHAFT, TROLLEY	3
611260	BRACKET, SLITTER CLAMP	1
611271	BRACKET, TROLLEY PIVOT	6
611280	AXLE, TROLLEY	6
611290	SLITTER ADJUST SCREW	7
611310	TROLLEY WHEEL	6

**ATLAS FOLDER
HEADROLL STAND ASSEMBLY 2611001**

CONTINUED

PART NO.	DESCRIPTION	QTY. REQ'D
611320	SLITTER, ARM	1
611330	SLITTER AXEL	1
611340	ANVIL SLITTER STUD SPACER	1
611350	SLITTER ANVIL BEARING STUD	1
611470	SHAFT, IDLER TIGHTNER	2
611841	MOUNT LAG BOLT	3
611970	MOUNT LAG BOLT	1
1611013	FRAME, HEADROLL OPERATOR SIDE	1
1611023	FRAME, HEADROLL GEAR SIDE	1
1611210	ANGLE SUPPORT GUARD	1
1611570	SPACER, PULLEY	1
2611041	PLATE, IDLER SUPPORT	2
2611083	HANDLE, SLITTER	1
2611093	HANDLE, UPPER TROLLEY	1
2611113	HANDLE, LOWER TROLLEY	1
2611240	PULLEY, HEADROLL DRIVE	1
2737050	STIFFENER, SHAFT	1
OPTION: 22-3/4 PULLEY DRIVE 2611000A2A		
061043	PULLEY, TIMING BELT, 22T X 7/8" P X 3" W, TYPE AF, WITH TAPER BUSHING	1
062009	TAPER BUSHING, 2-1/8" BORE	1

ATLAS FOLDER
OPTION: HEADROLL ASSEMBLY MANUAL CLUTCH
2611000A1

PART NO.	DESCRIPTION	QTY. REQ'D
2611101	DRIVE LINE ASSEMBLY	1
001026	BEARING, 1.7717 ID X 3.3465 OD	2
006006	PILLOW BLOCK BEARING 1-3/4 ID	2
030014	SNAP RING, 1.772 S.D. EXTERNAL	1
062027	TAPER BUSHING 2"	1
061041	20T X 1/2P X 1" W WITH TAPER BUSHING	1
1511260	FLANGE, DRIVE PULLEY	1
1511310	SPACER, BEARING UNIT CLUTCH (SCP)	1
1511321	CLUTCH PIN	7
1511430	SPACER, BEARING UNIT CLUTCH	1
1611422	SHAFT, MAIN DRIVE (SCP)	1
2611050	SHEAVE, FOLDER CLUTCH	1
2511330	CLUTCH HALF, MALE	1
2511370	DRIVE LINE CLUTCH (SCP)	1
2511380	DRIVE LINE CLUTCH, MALE	1
2611200	CLUTCH HANDLE ASSEMBLY	1
009002	7/16-20 X 1" OD	1
021005	SPRING	1
031004	ROLL PIN 1/4 DIA X 1" LONG	1
031034	SPIRAL ROLL PIN 1/4" X 5/8" LG	1
1511440	CLUTCH HANDLE (SCP)	1
1611510	BRACKET, LOCKING (SCP)	1
1611520	SUPPORT, CAM FOLLOWER	1
2611011	SUPPORT, CLUTCH SHAFT (SCP)	1
2611031	SHAFT, CLUTCH (SCP)	1

THIS DRAWING IS REPRESENTATIVE FOR IDENTIFICATION OF ACTUAL PARTS ONLY AND IS INCLUDED AS REFERENCE WHEN ORDERING REPLACEMENT PARTS FOR THE ATLAS 22 3/4" FOLDER. ALWAYS REFER TO THE PART NUMBERS WHEN ORDERING PARTS, INCLUDING THE SERIAL NUMBER OF THE FOLDER.

TOLERANCES (ACCEPT AS NOTED)		WEB PRESS LLC 701 EAST D ST., TACOMA, WA 98002	
DECIMAL	22-3/4 ATLAS	SCALE 1/4 X 1	DRAWN BY WEN APPROVED BY
FRACTIONAL	TITLE HEADROLL STAND AND HALF FOLD FRAMES		
ANGULAR	DATE 1-6-92	2611001 & 2612001 SHEET 1 OF 8	REVISION A

SLITTER ASSEMBLY
SEE SH 6 OF 8

UPPER TROLLEY ASSEMBLY
SEE SH 5 OF 8 (3 PLACES)

LOWER TROLLEY ASSEMBLY
SEE SH 5 OF 8 (3 PLACES)

1611013 HEAD ROLL
OPERATOR
SIDE

611150

2619002

GUARD ASSEMBLY

HEAD ROLL
GEAR SIDE 1611023

1/2-13 X 2" LONG SOCKET HEAD
1/2 SPLIT LOCKWASHER

1" ID X 1-5/8 032003
SET COLLAR

521460

611470

2611041

611470

1" ID X 1-5/8 032003
SET COLLAR

1611570

DROOP SNOOT FORMER
ASSEMBLY

2618001

2612330

STRIPPER AND GUIDES
ASSEMBLY

PRE FORM NIP ROLLS
ASSEMBLY

1613000

1612530

2612130

QUARTER FOLD
ASSEMBLY

1612250

1612260

001054

JAW
CYLINDER
ASSEMBLY

2616001

PIN
CYLINDER
ASSEMBLY

2615001

KNIFE
CYLINDER
ASSEMBLY

2614001

1612541

611841

5/8-11 X 1-1/2 LG SOCKET
HEAD
5/8 SPLIT LOCKWASHER

5/8 CEMENT BOLT
TYPICAL

1/2-13 X 2" LG SOCKET HEAD
1/2 SPLIT LOCKWASHER
(TYPICAL ON ALL STIFFENERS)

1/2-13 X 3" LG HEX HEAD
1/2-13 JAM NUT

1612040

9-1111-9

511260

1/2-13 X 2" LG SOCKET HEAD
1/2 SPLIT LOCKWASHER

3/4-10 X 2-1/2 LG HEX HEAD
3/4 SPLIT LOCKWASHER
3/4 FLAT WASHER

1612411

612110

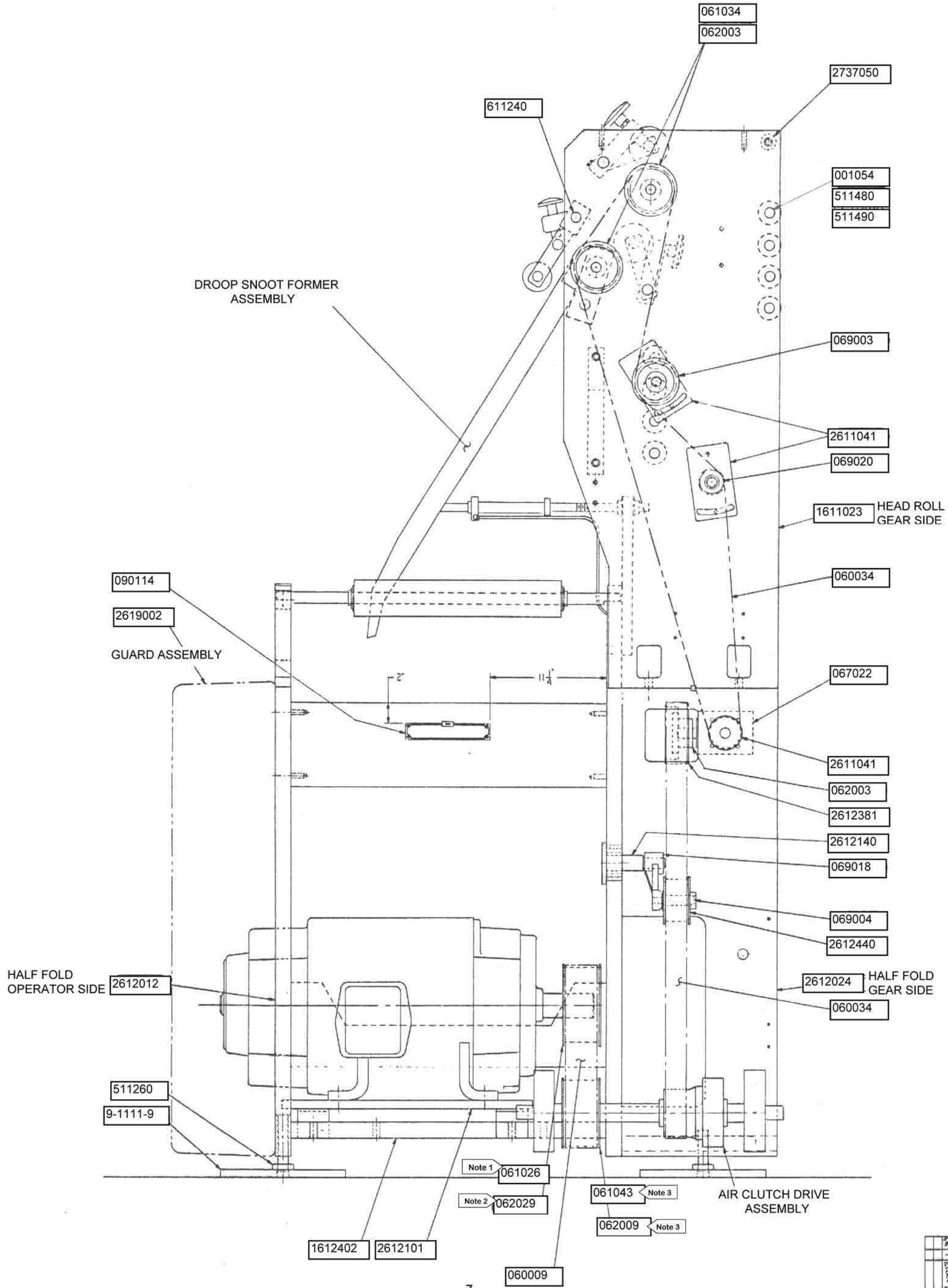
2612101

2612260

1612402

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TOLERANCES (ACCEPT AS NOTED)		WEB PRESS LLC 701 EAST D ST., TACOMA, WA 98002	
DECIMAL	22-3/4 ATLAS	SCALE 1/4 X 1	DRAWN BY WEN APPROVED BY
FRACTIONAL	TITLE HEADROLL STAND AND HALF FOLD FRAMES		
ANGULAR	DATE 1-6-92	2611001 & 2612001	REVISION A
		SHEET 2 OF 8	

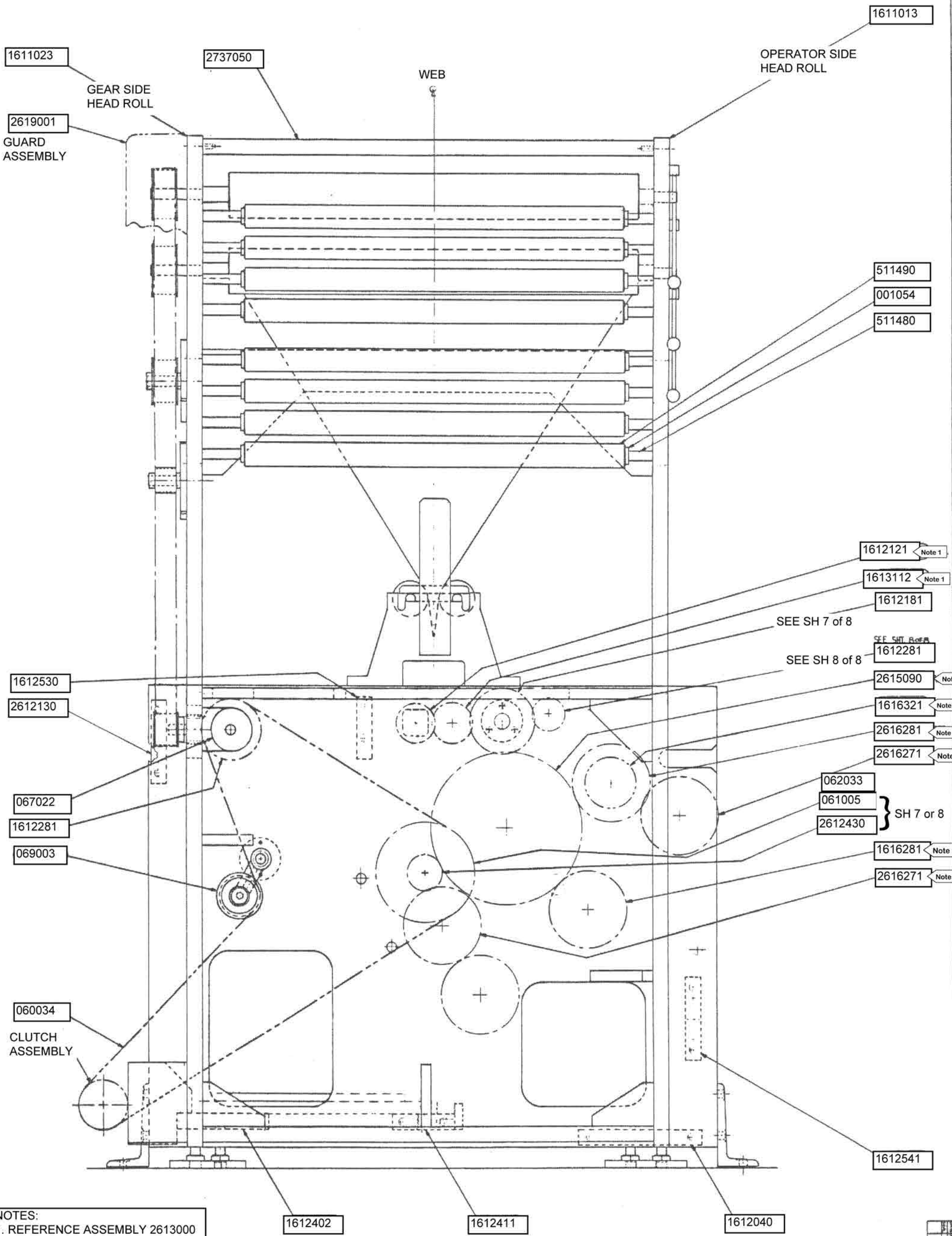


NOTES:
 1. REF ASSEMBLY 2612000A1
 2. REF ASSEMBLY 2612000A2
 3. REF ASSEMBLY 2611000A2A

DATE	1-6-92
DRAWN BY	WEN
CHECKED BY	
APPROVED BY	

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TOLERANCES (ACCEPT AS NOTED)		WEB PRESS LLC 701 EAST D ST., TACOMA, WA 98002	
DECIMAL	22-3/4 ATLAS	SCALE 1/4 X 1	DRAWN BY WEN APPROVED BY
FRACTIONAL	TITLE HEADROLL STAND AND HALF FOLD FRAMES		
ANGULAR	DATE 1-6-92	2611001 & 2612001 SHEET 3 OF 8	REVISION A



NOTES:
 1. REFERENCE ASSEMBLY 2613000
 2. REFERENCE ASSEMBLY 2615001
 3. REFERENCE ASSEMBLY 2616001
 4. REFERENCE ASSEMBLY 2625002
 5. REFERENCE ASSEMBLY 2614001
 6. REFERENCE ASSEMBLIES
 2723001
 2727000A
 2707000B

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TOLERANCES (ACCEPT AS NOTED)		WEB PRESS LLC 701 EAST D ST., TACOMA, WA 98002	
DECIMAL	22-3/4 ATLAS	SCALE 1/4 X 1	DRAWN BY WEN APPROVED BY
FRACTIONAL	TITLE HEADROLL STAND AND HALF FOLD FRAMES		
ANGULAR	DATE 1-6-92	2611001 & 2612001 SHEET 4 OF 8	REVISION A

TROLLEY ASSEMBLY
See Sh 5 of 8

SLITTER ASSEMBLY
See Sh 6 of 8

032003 1" ID X 1-5/8" OD DIAMETER
611240 SET COLLAR, INSIDE FRAME, BOTH SIDES

2611093

2611083

033001

3/8-16 SOCKET HEAD
(4 PLACES)

2611113

ASSEMBLY WITH
1/2 X 1/2 X 1-1/2 KEY STOCK
(BOTH SIDES)

5/8-11 NC2B X 2-1/4 HEX HEAD
5/8 SPLIT LOCKWASHER
5/8 FLAT WASHER

2619002

GUARD ASSEMBLY

2612390

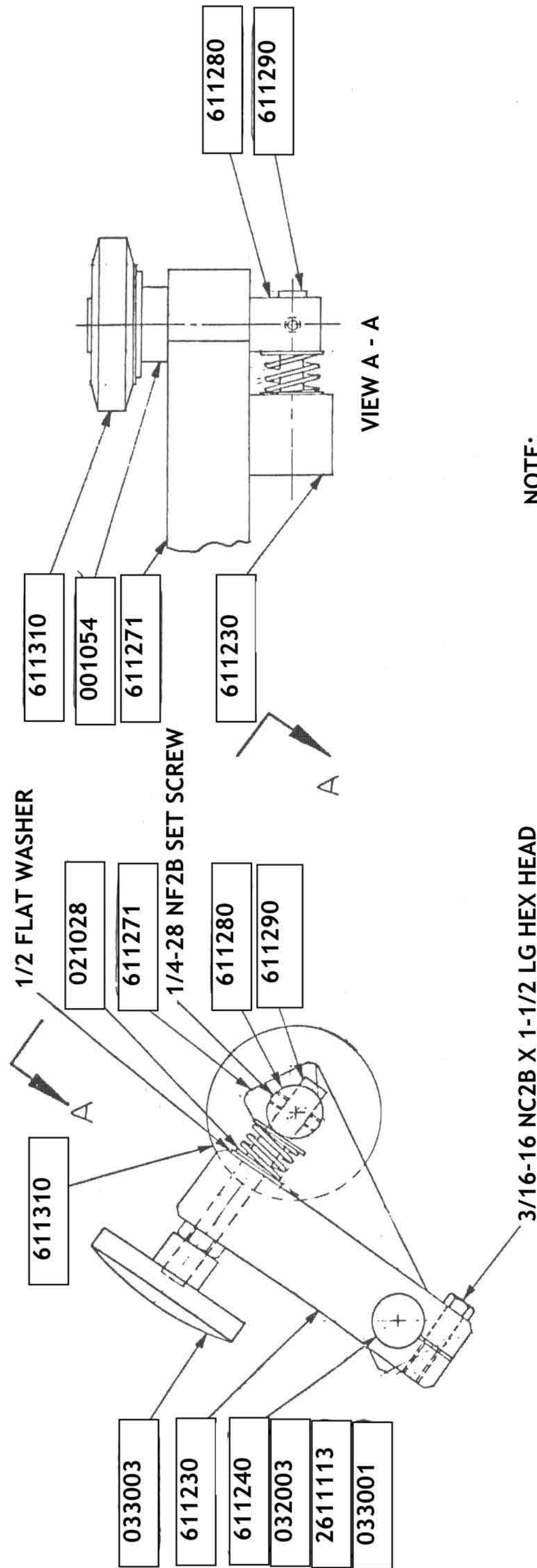
1/4-20 X 1" LG
SOCKET HEAD
1/4 SPLIT
LOCKWASHER

1611210

611841

1	1	1	1
2	2	2	2
3	3	3	3
4	4	4	4
5	5	5	5
6	6	6	6
7	7	7	7
8	8	8	8
9	9	9	9
10	10	10	10

1/2" 1" PERMANENT SEE FINE COPY CAL304 USA

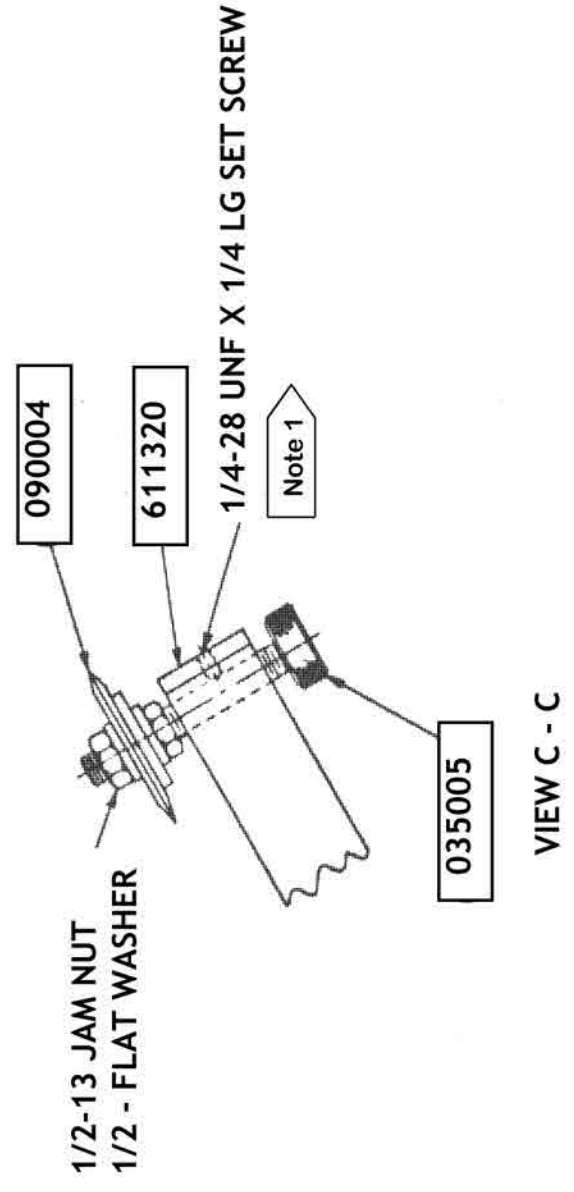
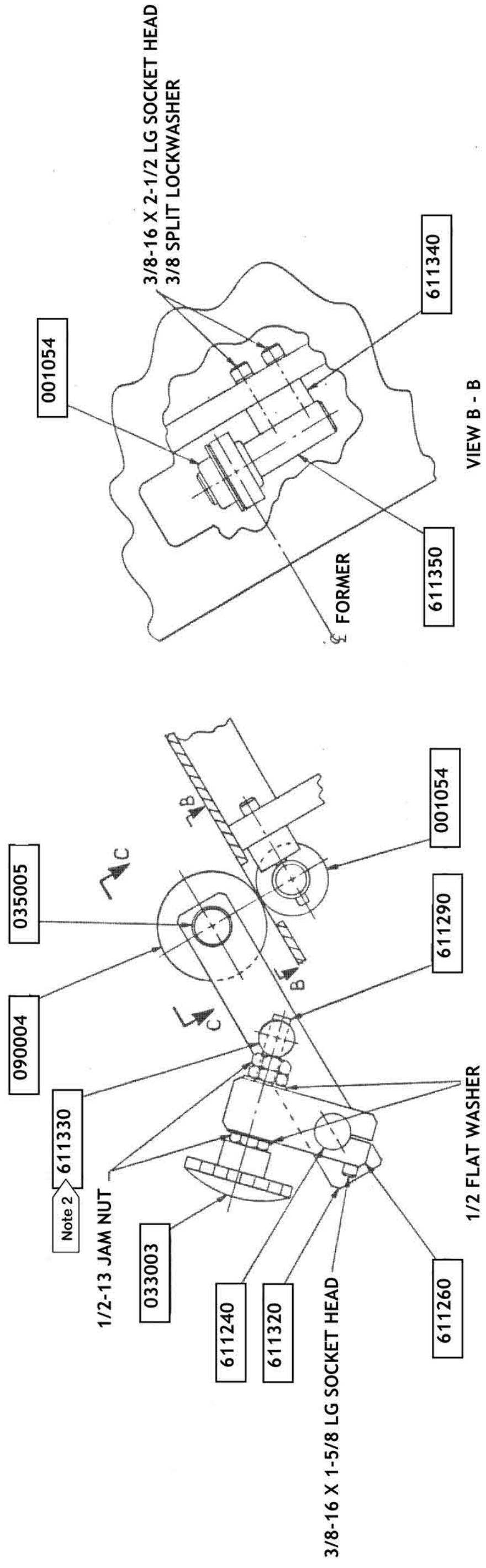


NOTE:
USE NYLON INSERTS UNDER SET SCREWS

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TOLERANCES (ACCEPT AS NOTED)	WEB PRESS LLC 701 EAST D ST., TACOMA, WA 98002		DRAWN BY WEN
DECIMAL	SCALE	1/4 X 1	APPROVED BY
FRACTIONAL	TITLE HEADROLL STAND AND HALF FOLD FRAMES		
ANGULAR	DATE	1-6-92	REVISION A
	SHEET	5 OF 8	

DATE	REVISION	BY	CHK
	1	A	
	2		
	3		
	4		
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	6		
	7		
	8		
	9		
	10		



Note 1 USE NYLON INSERTS UNDER ALL SET SCREWS ON TOLLEYS AND SLITTERS

Note 2 USE THRUST WASHERS 005005 BETWEEN SNAP RING AND BLOCK TO REDUCE EXCESSIVE PLAY.

TOLERANCES (ACCEPT AS NOTED)	WEB PRESS LLC 701 EAST D ST., TACOMA, WA 98002		DRAWN BY WEN
DECIMAL	SCALE 1/4 X 1	APPROVED BY	
FRACTIONAL	TITLE HEADROLL STAND AND HALF FOLD FRAMES		
ANGULAR	DATE 1-6-92	2611001 & 2612001	REVISION A
	SHEET 6 OF 8		

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Note: Pages 12 & 13 removed with May 2018 revision

ATLAS FOLDER
OPTION: HORTON AIR CLUTCH WITH PULLEY-30 TEETH
2611000B3

Reference Drawing 2611203

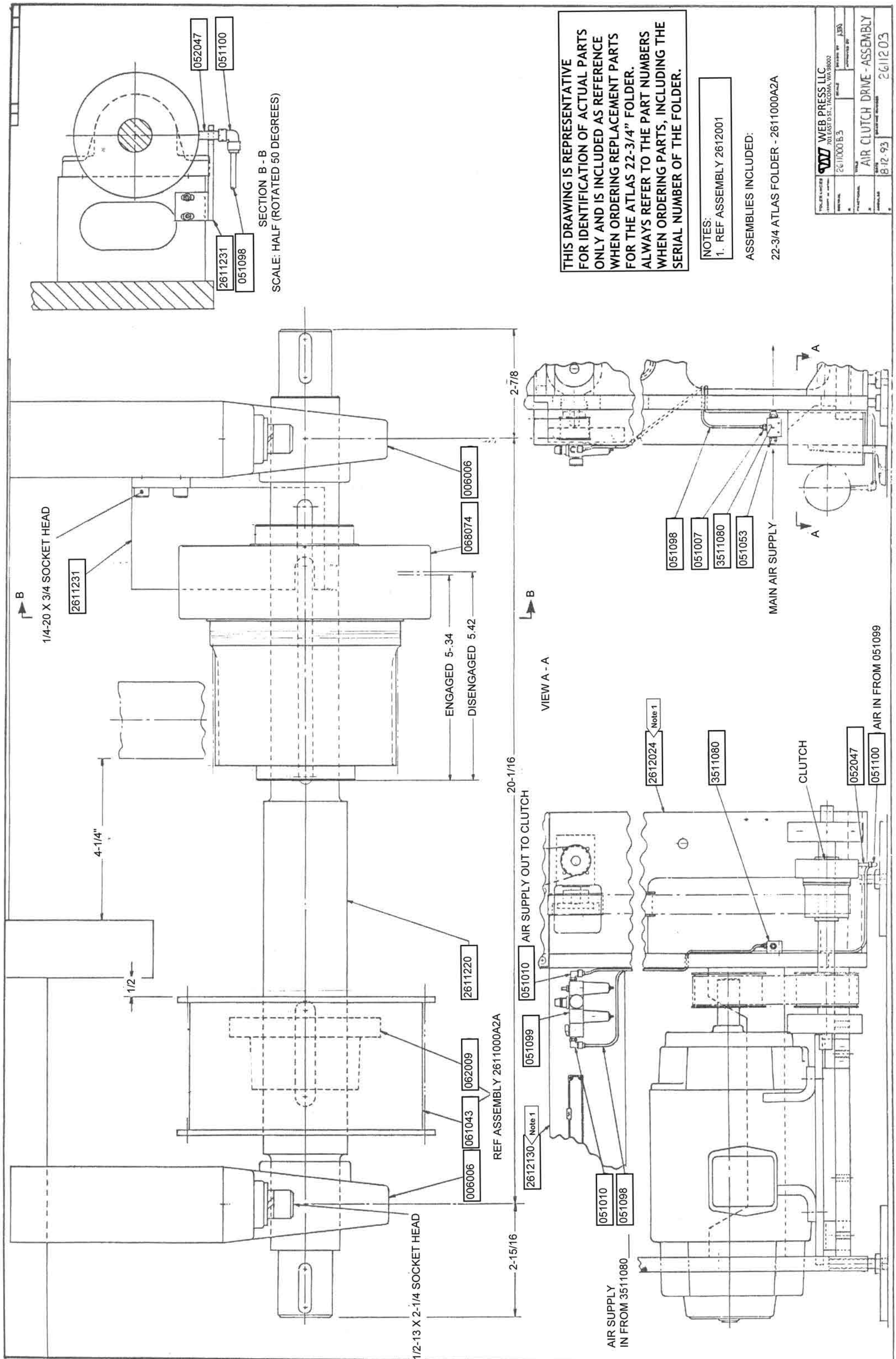
PART NO.	DESCRIPTION	QTY. REQ'D
006006	PILLOW BLOCK 1-3/4" ID	2
051007	CONNECTOR, STRAIGHT MALE, BRASS 1/4"NPT X 1/4"T	2
051010	ELBOW, 360° SWIVEL, BRASS 1/4" NPT X 1/4" NPT	2
051053	CONNECTOR, STRAIGHT MAILE, 3/8"NPT X 1/2"T	2
051098	TUBING, POLYETHELENE, 1/8" X 1/4"OD	12 FT
051099	FILTER, PNEUMATIC, REGULATOR/ GAUGE, VALVE WATTS 35 SERIES	1
051100	ELBOW, FEMALE, 1/4"OD TUBE X 1/8"FEMALE PIPE	1
052045	NIPPLE. 1/8" NPT X 1-1/2" LONG	1
068074	CLUTCH, HORTON AIR, WITH 30-H200 PULLEY 5H50TP	1
2611220	SHAFT, MAIN DRIVE (FOLDER)	1
2611231	BRACKET, CLUTCH (FOLDER)	1
3511080	MANIFOLD	1

22-3/4 PULLEY DRIVE 2611000A2A

Reference Drawing 2611203

061043	PULLEY, 22 XH 300	1
062009	TAPER BUSHING, 2-1/8" 20 BORE	1

NOTE: ALSO INCLUDE WITH PARTS LIST 2611000B3
051014 PIPE PLUG 1 EACH



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NOTES:
1. REF ASSEMBLY 2612001

ASSEMBLIES INCLUDED:
22-3/4 ATLAS FOLDER - 2611000A2A

70 EAST D ST., TACOMA, WA 98002	
2611000 B 3	REVISED BY JBA
AIR CLUTCH DRIVE - ASSEMBLY	PART NUMBER 2611203
DATE 8.12.93	PROJECT NUMBER 2611203



Half Fold Main Drive Assembly

**ATLAS FOLDER
HALF FOLD MAIN DRIVE ASSEMBLY 2612001**

PART NO.	DESCRIPTION	QTY. REQ'D
9-1111-9	LEVELING PAD, ATLAS FOLDER	4
001054	BALL BEARING ER-16X (LOW DRAG)	2
001006	BALL BEARING, 1-3/4" ID X 3.3465" OD	2
001020	BALL BEARING, 1-1/4" ID X 2.8346" OD (SEALMASTER ONLY)	2
001023	BALL BEARING, 1.5748" ID X 2.6772" OD	1
001024	BALL BEARING, 1.7717" ID X 2.9528" OD	1
032011	SET COLLAR, 1-1/8" ID X 1-3/4" OD	1
060009	TIMING BELT, 7/8" P X 3" W X 63" LG	1
060034	TIMING BELT, 1/2" P X 2" W X 125" LONG	1
061005	PULLEY, TIMING BELT, 60T X 1/2" P X 2" W WITH TAPER BUSHING	1
061008	PULLEY, TIMING BELT, 26T X 7/8" P X 3" W WITH TAPER BUSHING	1
062003	TAPER BUSHING, 1" BORE	1
062033	TAPER BUSHING 1-3/4" BORE	1
069004	IDLER, SHAFT, 1" DIA 3-1/8" SL	1
069014	LOCKING ASSEMBLY, 32 X 36	2
069018	IDLER BRACKET	1
612110	SCREW PAD TAKE-UP	1
613180	PELLET, NIP ROLL	2
1612040	STIFFENER, REAR (1/2 FOLD)	1
1612170	IDLER PIN	1
1612181	GEAR, IDLER	1
1612220	RETAINER WASHER	1
1612230	SPACER, BEARING	1
1612250	SHAFT STIFFENER	1
1612260	ROLLER CORE	1
1612270	CAP, BELT DRIVE GEAR	1
1612281	GEAR, BELT DRIVE	1
1612290	SHAFT, BELT DRIVE	1
1612311*	IDLER TAPE	1

*Note: for Quarter Fold 2657000

ATLAS FOLDER
HALF FOLD MAIN DRIVE ASSEMBLY 2612001

CONTINUED

PART NO.	DESCRIPTION	QTY. REQ'D
1612402	STIFFENER, PILLOW BLOCK HALF FOLD	1
1612411	STIFFENER, CENTER (1/2 FOLD)	1
1612530	STIFFENER, 6" WIDE (1/2 FOLD)	1
1612541	STIFFENER, (1/2 FOLD)	1
2612012	FRAME, HALF FOLD OPERATOR SIDE	1
2612024	FRAME, HALF FOLD GEAR SIDE	1
2612101	PLATE, MOTOR MOUNTING	1
2612130	STIFFENER, 8" WIDE (1/2 FOLD)	1
2612140	BRACKET, SUPPORT	1
2612260	BLOCK, SCREW ADJUSTING	1
2612330	SHAFT, QUARTERFOLD PIVOT	1
2612381	PULLEY, HEAD DRIVER	1
2612390	CONDUIT MOUNT	1
2612400	SUPPORT PIN, FOLDER	2
2612410	SUPPORT PLATE (ATLAS FOLDER)	1
2612420	DRIVE SHAFT, ATLAS FOLDER	1
2612430	FOLDER DRIVE GEAR (261 ONLY)	1
2612440	PULLER, IDLER	1
2657800**	UPPER TAPE DRIVE (22-3/4)	2
OPTION: BALDOR DC MOTOR 40/50 HP DRIVE 2612000A1		
062026	TAPER BUSHING, 2-1/8" BORE	1
OPTION: BALDOR DC MOTOR 60/75/100 HP DRIVE 2612000A2		
062029	TAPER BUSHING, 2-3/8" BORE	1
OPTION: FOLDER HANDWHEEL 2612000B1		
811041	HANDWHEEL, UNIT	1

* Note: For Quarter Fold 2617001

** Note: For Quarter Fold 2657000

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TOLERANCES (ACCEPT AS NOTED)		WEB PRESS LLC 701 EAST D ST., TACOMA, WA 98002	
DECIMAL	22-3/4 ATLAS	SCALE 1/4 X 1	DRAWN BY WEN APPROVED BY
FRACTIONAL	TITLE HEADROLL STAND AND HALF FOLD FRAMES		
ANGULAR	DATE 1-6-92	2611001 & 2612001 SHEET 1 OF 8	REVISION A

SLITTER ASSEMBLY
SEE SH 6 OF 8

UPPER TROLLEY ASSEMBLY
SEE SH 5 OF 8 (3 PLACES)

LOWER TROLLEY ASSEMBLY
SEE SH 5 OF 8 (3 PLACES)

1611013 HEAD ROLL
OPERATOR
SIDE

611150

2619002

GUARD ASSEMBLY

HEAD ROLL
GEAR SIDE 1611023

1/2-13 X 2" LONG SOCKET HEAD
1/2 SPLIT LOCKWASHER

1" ID X 1-5/8 032003
SET COLLAR

521460

611470

2611041

611470

1" ID X 1-5/8 032003
SET COLLAR

1611570

DROOP SNOOT FORMER
ASSEMBLY

2618001

2612330

STRIPPER AND GUIDES
ASSEMBLY

PRE FORM NIP ROLLS
ASSEMBLY

1613000

1612530

2612130

QUARTER FOLD
ASSEMBLY

1612250

1612260

001054

JAW
CYLINDER
ASSEMBLY

2616001

PIN
CYLINDER
ASSEMBLY

2615001

KNIFE
CYLINDER
ASSEMBLY

2614001

1612541

611841

5/8-11 X 1-1/2 LG SOCKET
HEAD
5/8 SPLIT LOCKWASHER

5/8 CEMENT BOLT
TYPICAL

1/2-13 X 2" LG SOCKET HEAD
1/2 SPLIT LOCKWASHER
(TYPICAL ON ALL STIFFENERS)

1/2-13 X 3" LG HEX HEAD
1/2-13 JAM NUT

1612040

9-1111-9

511260

1/2-13 X 2" LG SOCKET HEAD
1/2 SPLIT LOCKWASHER

3/4-10 X 2-1/2 LG HEX HEAD
3/4 SPLIT LOCKWASHER
3/4 FLAT WASHER

1612411

612110

2612101

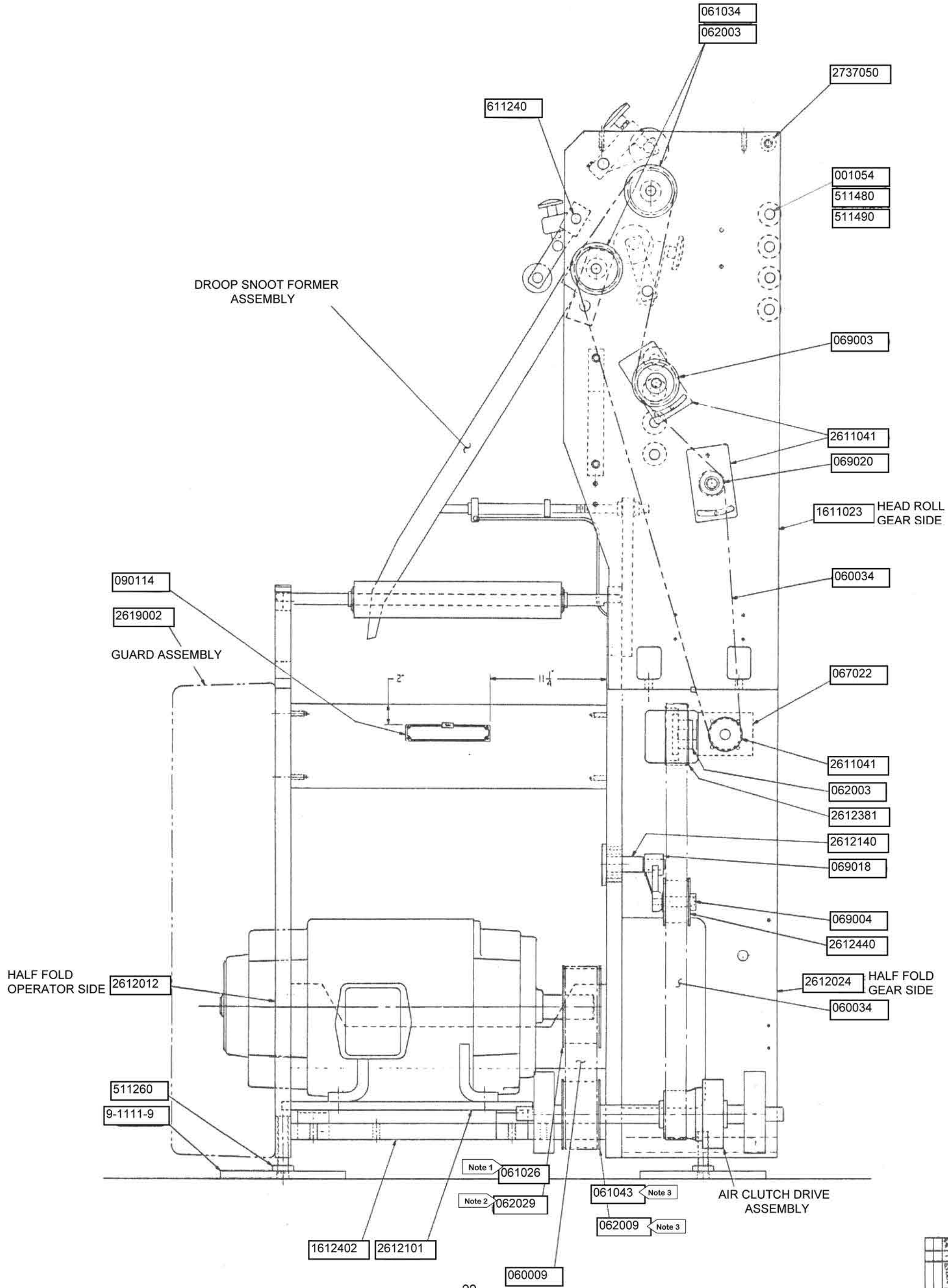
2612260

1612402

DATE	1-6-92
DRAWN BY	WEN
CHECKED BY	
APPROVED BY	

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TOLERANCES (ACCEPT AS NOTED)	WEB PRESS LLC 701 EAST D ST., TACOMA, WA 98002		DRAWN BY WEN
DECIMAL	22-3/4 ATLAS	SCALE 1/4 X 1	APPROVED BY
FRACTIONAL	TITLE HEADROLL STAND AND HALF FOLD FRAMES		
ANGULAR	DATE 1-6-92	2611001 & 2612001	REVISION A
	SHEET 2 OF 8		

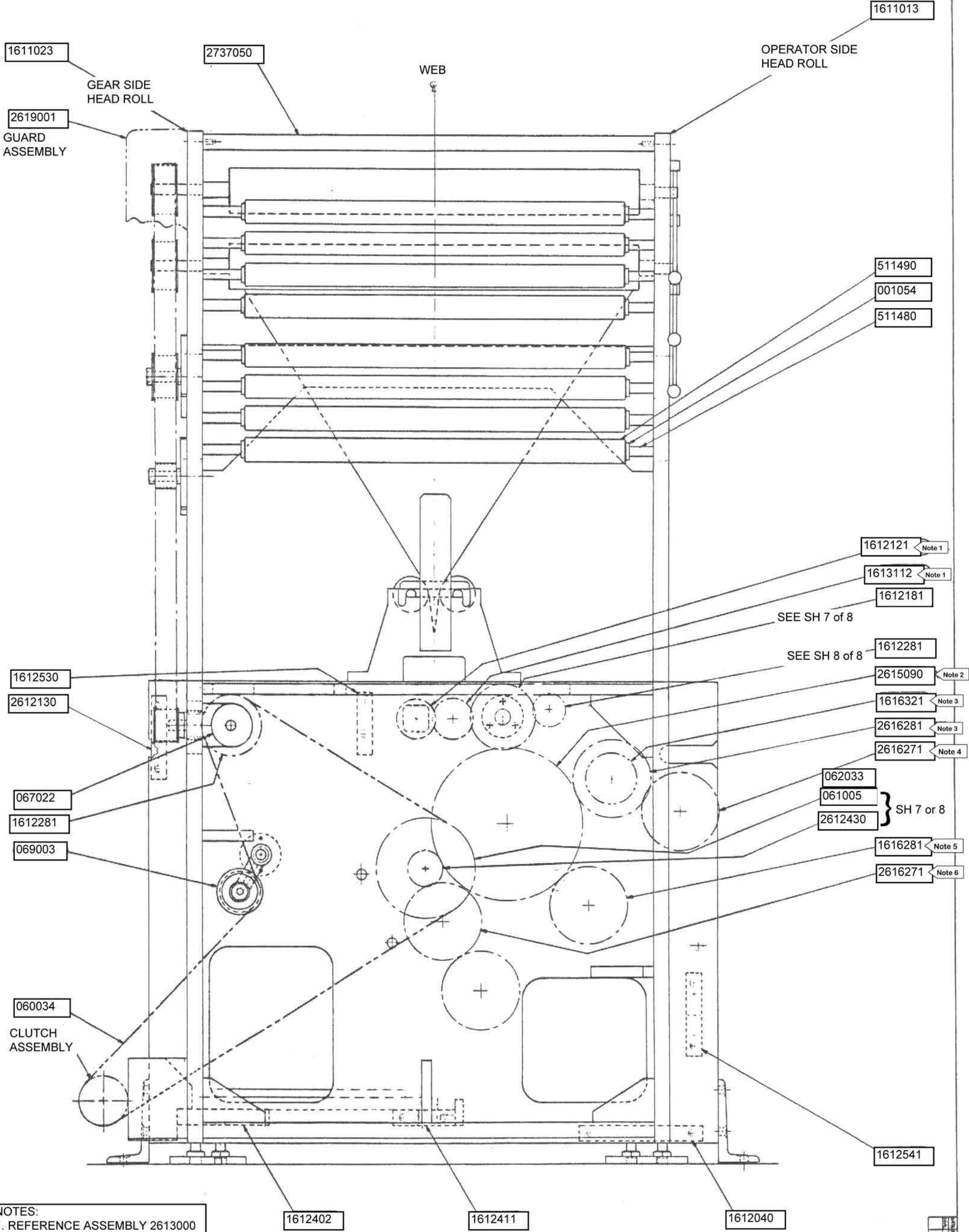


NOTES:
 1. REF ASSEMBLY 2612000A1
 2. REF ASSEMBLY 2612000A2
 3. REF ASSEMBLY 2611000A2A

DATE	1-6-92
DRAWN BY	WEN
CHECKED BY	
APPROVED BY	

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TOLERANCES (ACCEPT AS NOTED)		WEB PRESS LLC 701 EAST D ST., TACOMA, WA 98002	
DECIMAL	22-3/4 ATLAS	SCALE 1/4 X 1	DRAWN BY WEN APPROVED BY
FRACTIONAL	TITLE HEADROLL STAND AND HALF FOLD FRAMES		
ANGULAR	DATE 1-6-92	2611001 & 2612001 SHEET 3 OF 8	REVISION A



NOTES:
 1. REFERENCE ASSEMBLY 2613000
 2. REFERENCE ASSEMBLY 2615001
 3. REFERENCE ASSEMBLY 2616001
 4. REFERENCE ASSEMBLY 2625002
 5. REFERENCE ASSEMBLY 2614001
 6. REFERENCE ASSEMBLIES
 2723001
 2727000A
 2707000B

NO.	REV.	DATE	BY	CHKD.

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TOLERANCES (ACCEPT AS NOTED)		WEB PRESS LLC 701 EAST D ST., TACOMA, WA 98002	
DECIMAL	22-3/4 ATLAS	SCALE 1/4 X 1	DRAWN BY WEN APPROVED BY
FRACTIONAL	TITLE HEADROLL STAND AND HALF FOLD FRAMES		
ANGULAR	DATE 1-6-92	2611001 & 2612001 SHEET 4 OF 8	REVISION A

TROLLEY ASSEMBLY
See Sh 5 of 8

SLITTER ASSEMBLY
See Sh 6 of 8

032003 1" ID X 1-5/8" OD DIAMETER
611240 SET COLLAR, INSIDE FRAME, BOTH SIDES

2611093

2611083

033001

3/8-16 SOCKET HEAD
(4 PLACES)

2611113

ASSEMBLY WITH
1/2 X 1/2 X 1-1/2 KEY STOCK
(BOTH SIDES)

5/8-11 NC2B X 2-1/4 HEX HEAD
5/8 SPLIT LOCKWASHER
5/8 FLAT WASHER

2619002

GUARD ASSEMBLY

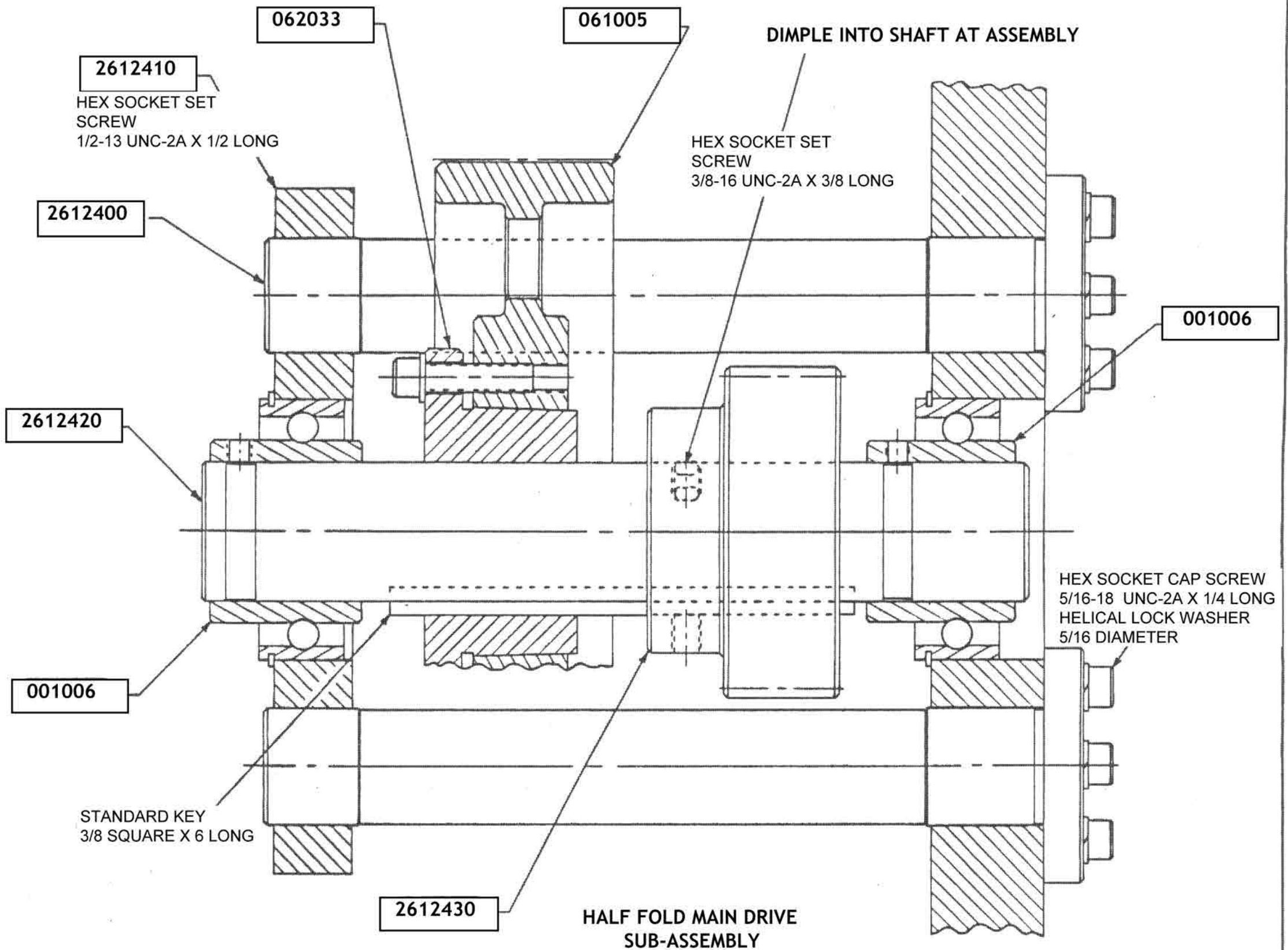
2612390

1/4-20 X 1" LG
SOCKET HEAD
1/4 SPLIT
LOCKWASHER

1611210

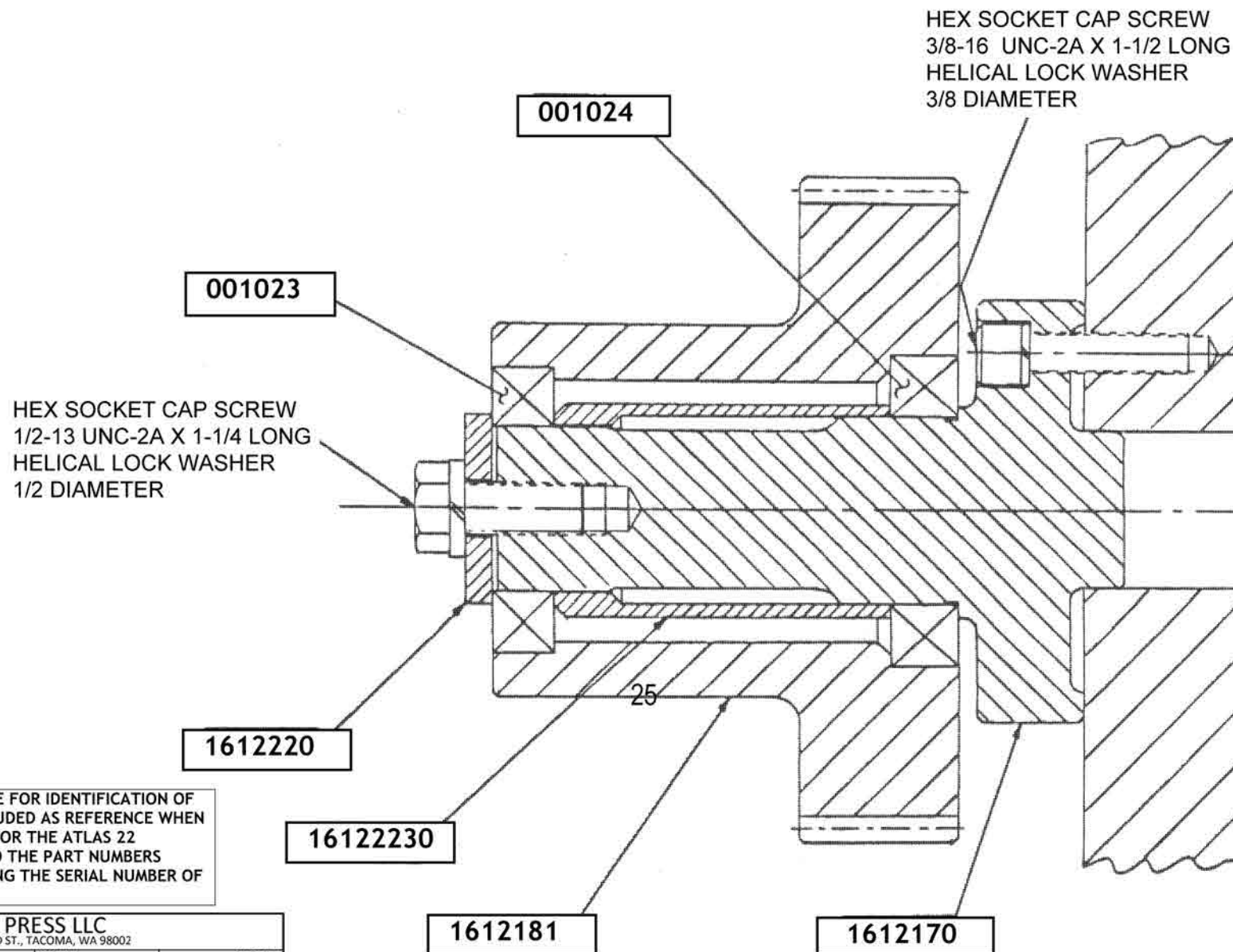
611841

1	1	1	1
2	2	2	2
3	3	3	3
4	4	4	4
5	5	5	5
6	6	6	6
7	7	7	7
8	8	8	8
9	9	9	9
10	10	10	10



STANDARD KEY
3/8 SQUARE X 6 LONG

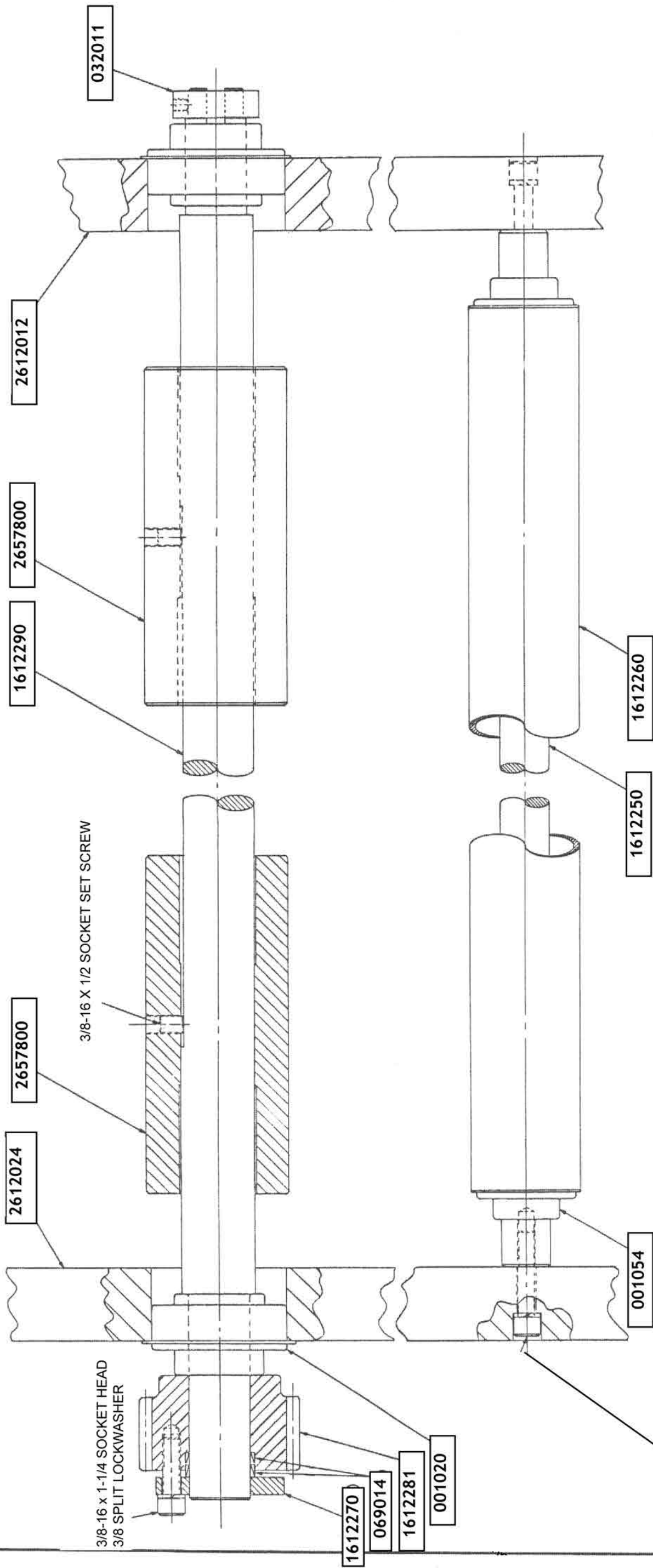
**HALF FOLD MAIN DRIVE
SUB-ASSEMBLY**



**NIP ROLL IDLER DRIVE
SUB-ASSEMBLY**

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TOLERANCES (ACCEPT AS NOTED)		WEB PRESS LLC 701 EAST D ST., TACOMA, WA 98002	
DECIMAL	SCALE	DRAWN BY WEN	
.	1/4 X 1	APPROVED BY	
FRACTIONAL	TITLE HEADROLL STAND AND HALF FOLD FRAMES		
.	DATE 1-6-92		
ANGULAR	2611001 & 2612001		REVISION A
.	SHEET 7 OF 8		



WEB PRESS LLC <small>701 EAST D ST., TACOMA, WA 98002</small>		SCALE 1/4 X 1	DRAWN BY WEN
TOLERANCES (ACCEPT AS NOTED)	DECIMAL	FRACTIONAL	APPROVED BY
*	*	*	*
ANGULAR	*	*	*
TITLE HEADROLL STAND AND HALF FOLD FRAMES		DATE 1-6-92	REVISION A
SHEET 8 OF 8		DATE 2611001 & 2612001	

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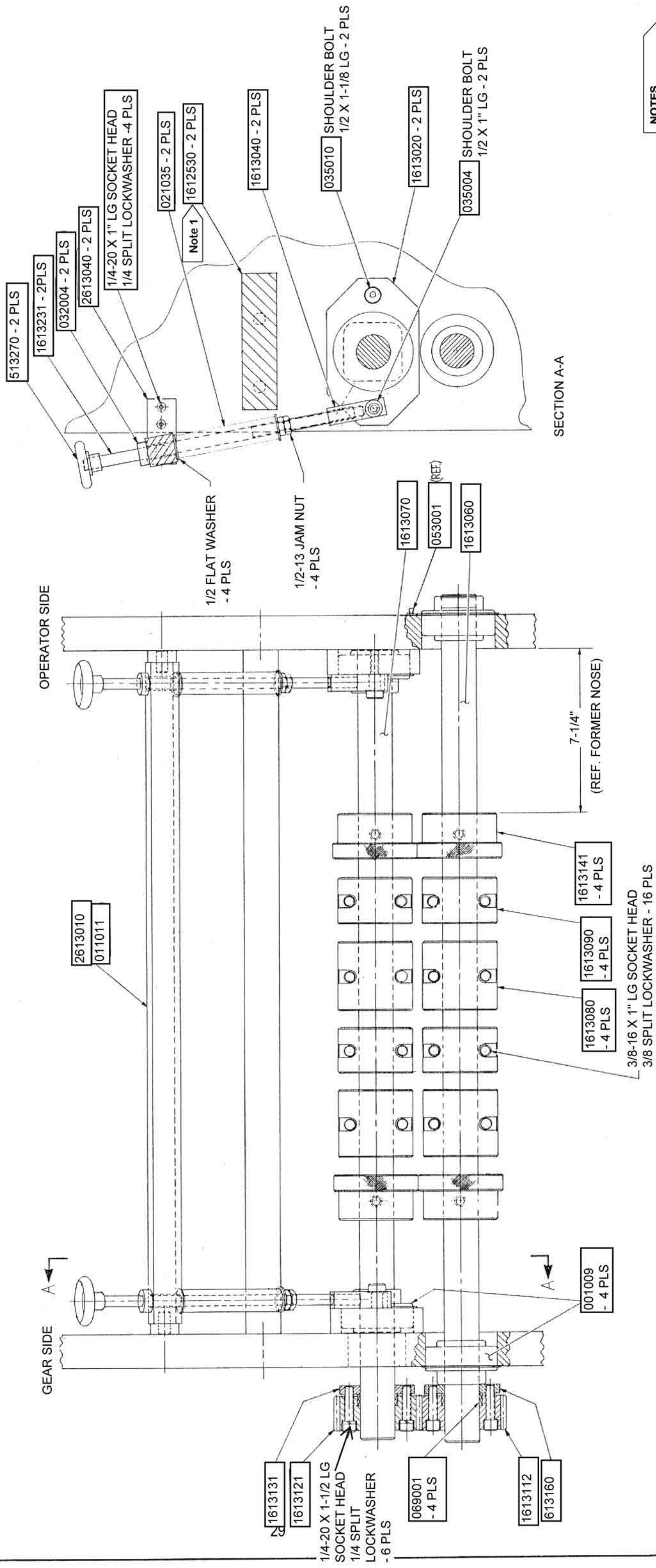


Pre-Form & Nip Roll Assembly

ATLAS FOLDER
PRE-FORM AND NIP ROLL ASSEMBLY 2613000

PART NO.	DESCRIPTION	QTY. REQ'D
001009	BALL BEARING, ER-24, 1-1/2"ID X 3.1496"OD	4
011011	BUSHING, OILITE, 7/8"ID X 1"OD X 1" LONG WITH FLANGE	2
021035	COMPRESSION SPRING, (BLUE) 1/2"ID X 1"OD X 4-1/2" LG	2
032004	SET COLLAR, 1/2"ID X 1"OD	2
035004	BOLT, SHOULDER 1/2"DIA. X 1" LONG	2
035010	BOLT, SHOULDER 1/2"DIA. X 1-1/8" LONG	2
069001	LOCKING ASSEMBLY, 38 X 44	4
513270	KNOB	2
613160	CAP, NIP ROLL GEAR	1
1613020	PLATE, NIP ROLL SWING	2
1613040	SWING PIVOT BAR, NIP ROLL	2
1613060	SHAFT, NIP ROLL STATIONARY	1
1613070	SHAFT, NIP ROLL MOVEABLE	1
1613080	SPACER, PINCH ROLL	4
1613090	SPACER, PINCH ROLL	4
1613112	GEAR, NIP ROLL (RIGHT HAND)	1
1613121	GEAR, NIP ROLL (LEFT HAND)	1
1613131	CAP, NIP ROLL GEAR	1
1613141	NIP ROLL, HALF FOLD (ATLAS)	4
1613231	ROD, NIP ROLL ADJUSTING	2
2613010	BAR, NIP ROLL ADJUSTING	1
2613040	HOLDER, NIP ROLL ADJUSTING	2

DATE	BY	REVISION



NOTES
REFERENCE
ASSEMBLY
1. 2612001

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TOLERANCES UNLESS SHOWN OTHERWISE	WEB PRESS LLC 701 EAST D ST., TACOMA, WA 98602		
DRAWING NO.	TITLE	SCALE	DATE
	ASSY. PRE FORM NIP ROLLS	1/2" = 1"	11-21-89

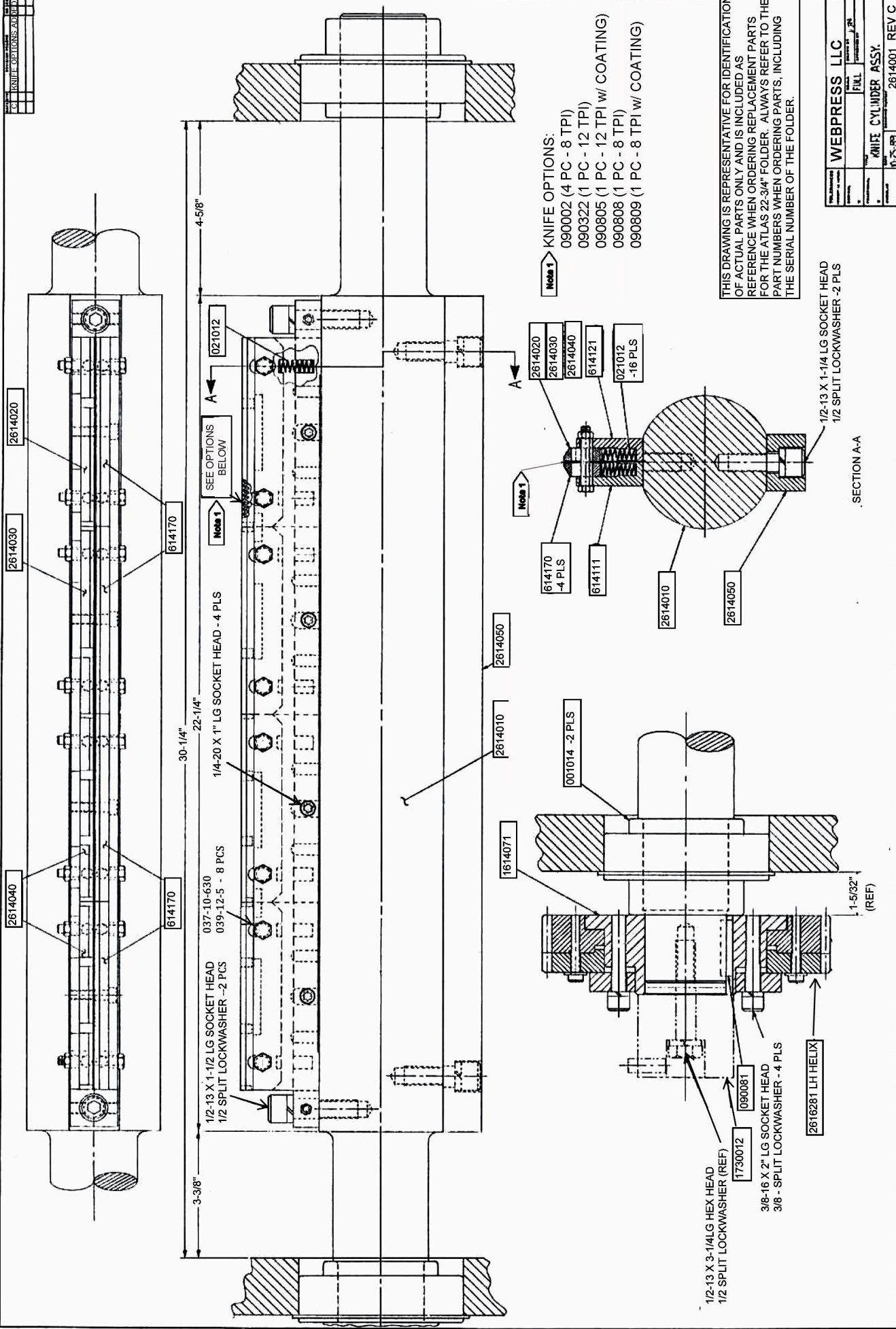


Knife Cylinder Assembly

**ATLAS FOLDER
KNIFE CYLINDER ASSEMBLY 2614001**

PART NO.	DESCRIPTION	QTY. REQ'D
001014	BALL BEARING ER-36, 2-1/4"ID X 4.33"OD .0001/.0003 FIT	2
090081	WOODRUFF KEY, #1012, 5/16" X 1-1/2"	1
1614071	HUB, GEAR BACKLASH	1
2614100	HALF BOX KNIFE BOX ASSEMBLY	1
021012	COMPRESSION SPRING, .300"OD X 1-1/4" LG X .32"WIRE	16
*090322	KNIFE, CUT-OFF, SERRATED, 20" X 2-1/8"	1
614111	BAR, CUTTING KNIFE	1
614121	BAR, CUTTING KNIFE	1
614170	CHEEKWOOD, CUTTING KNIFE	4
2614020	CHEEKWOOD	1
2614030	CHEEKWOOD	1
2614040	CHEEKWOOD	2
2616281	GEAR, LEFT HAND	1
2614050	COUNTER WEIGHT	1
OPTION: STANDARD OR DOUBLE PARALLEL 2614000A1		
2614010	KNIFE CYLINDER	1
OPTION: 22-3/4 ATLAS DOUBLE DIGEST / COMBINATION KNIFE CYLINDER ASSEMBLY 2634000A1		
2634010	KNIFE CYLINDER	1
OPTION: 22-3/4 ATLAS DOUBLE DIGEST / COMBINATION KNIFE CYLINDER ASSEMBLY 2634000A2		
2614100	HALF BOX KNIFE BOX ASSEMBLY	1

*or 090002 4 piece knife 4



Part Number	2614001
Description	KNIFE CYLINDER ASSY.
Rev	REV C
Date	12/17
Drawn By	10-25-93
Checked By	
Approved By	
Company	WEBPRESS LLC
Address	
City	
State	
Zip	

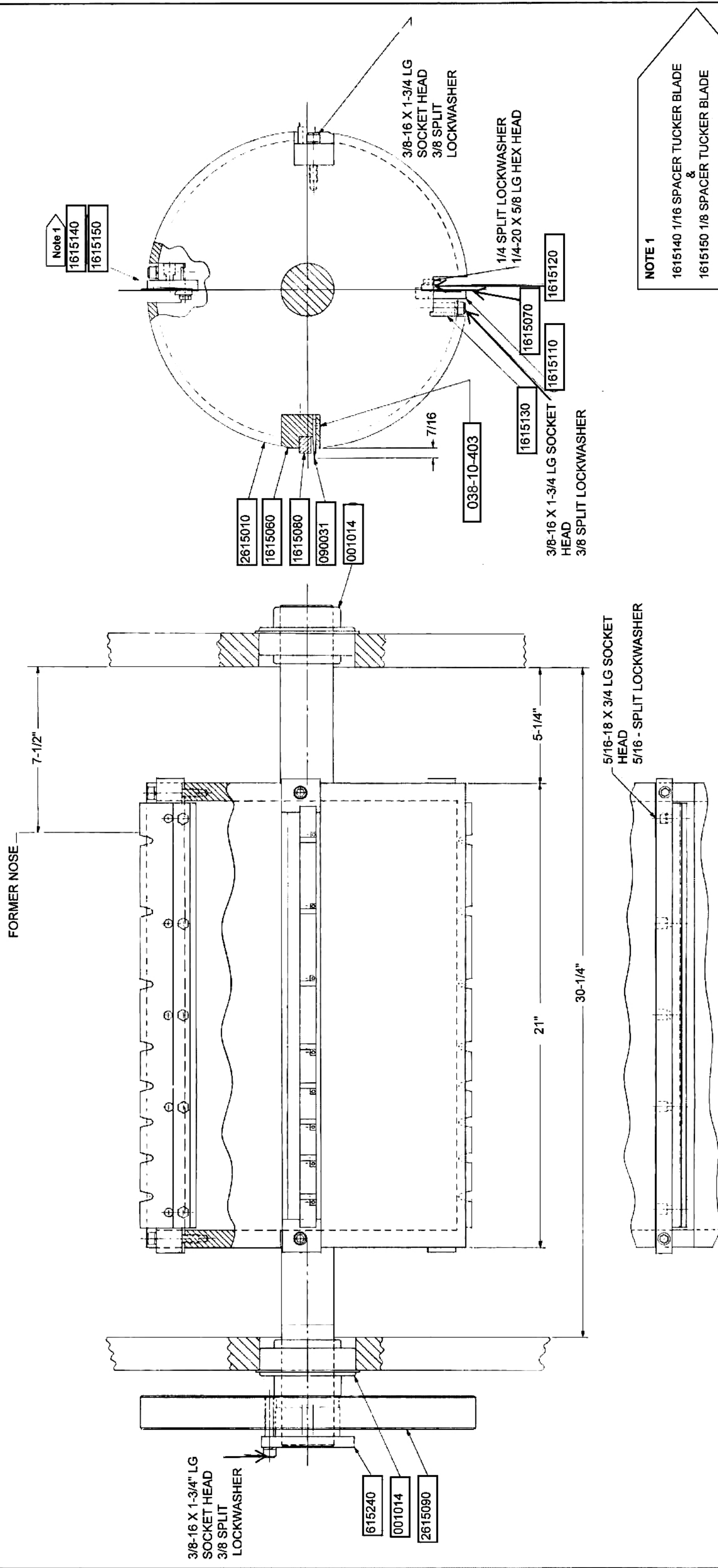


Pin Cylinder Assembly

**ATLAS FOLDER
PIN CYLINDER ASSEMBLY 2615001**

PART NO.	DESCRIPTION	QTY. REQ'D
001014	BALL BEARING ER-36I, 2-1/4"ID X 4.33OD .0001 / .0003 FIT	2
090031	PIN, PICKER, 1/8" X 1-3/4" X 7/8" POINT	16
615240	BULL GEAR, BUSHING	1
1615070	TUCKER BLADE	2
1615080	CUTTING RUBBER (BLACK)	2
1615110	PLATE, TUCKER BLADE SUPPORT	2
1615120	PLATE, TUCKER	2
1615130	BAR, TUCKER BALDE PIN CYLINDER	2
1615140	SPACER, TUACKER BLADE	2
1615150	SPACER, TUCKER BLADE	2
2615090	BULL GEAR (22-3/4")	1
OPTION: STANDARD / DOUBLE PARALLEL 2615000A1		
2615010	PIN CYLINDER DRUM	1
OPTION: STANDARD PIN CYLINDER 2615000A2		
1615060	BAR, PIN MOUNTING (ATLAS FOLDER)	2
OPTION: 22-3/4 ATLAS DOUBLE DIGEST / COMBINATION PIN CYLINDER 2635000A1		
2635010	PIN CYLINDER DRUM DOUBLE DIGEST	1
1635030	FILLER BAR	4
OPTION: 22-3/4 ATLAS DOUBLE DIGEST / COMBINATION PIN CYLINDER 2635000A2		
090031	PICKER PIN	16
2615070	TUCKER BLADE (SCP2)	2
1615080	CUTTING RUBBER (BLACK)	4
1615110	PLATE, TUCKER BLADE SUPPORT	2
1615120	PLATE, TUCKER	2
1615130	BAR, TUCKER BLADE PIN CYLINDER	2
1615140	SPACER, TUCKER BLADE	2
1615150	SPACER, TUCKER BLADE	2
1635020	BAR, PIN MOUNTING (O.D.P.)	4

REV	DATE	BY



NOTE 1
 1615140 1/16 SPACER TUCKER BLADE
 &
 1615150 1/8 SPACER TUCKER BLADE
 SHIPPED LOOSE.
 INSTALLED IF NEEDED.

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TOLERANCES UNLESS OTHERWISE SPECIFIED		WEB PRESS, LLC 701 EAST O ST., TACOMA, WA 98002	
FINISH	22-3/4" ATLAS	SCALE	HALF
PROJECT	PIN CYL. ASSY	DATE	10-19-89
REV	2615001	REV A	REV A



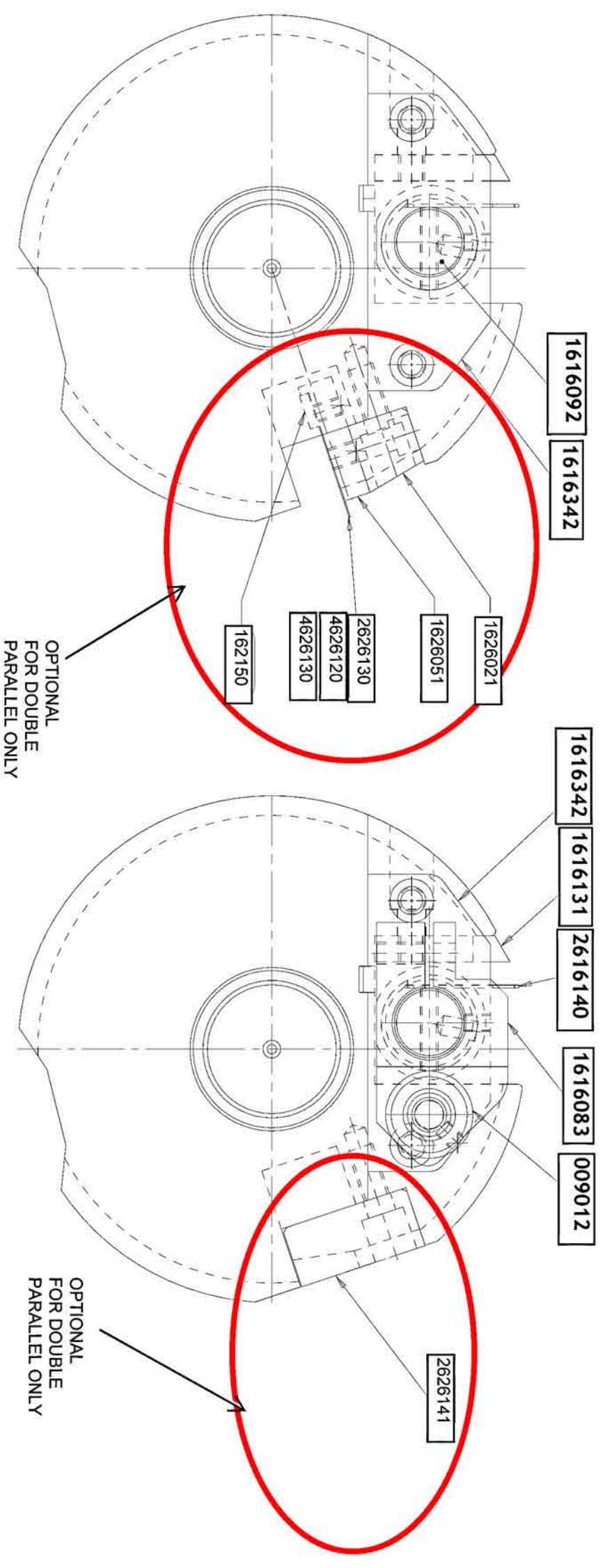
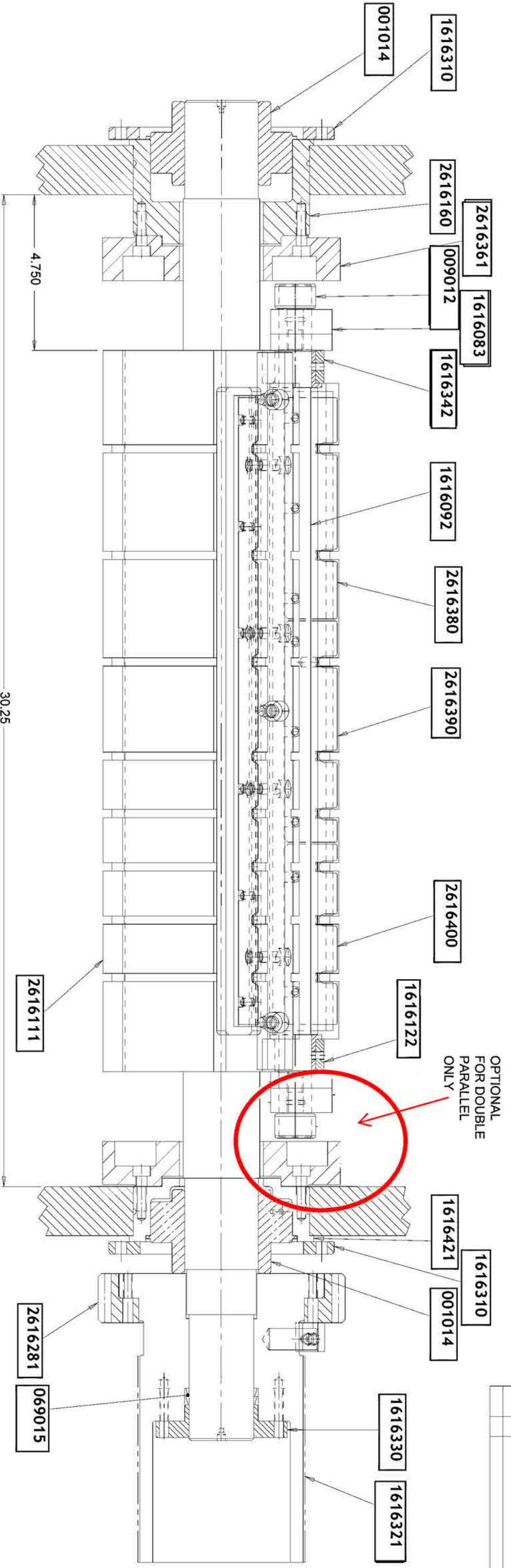
Jaw Cylinder Assembly

ATLAS FOLDER

1st JAW CYLINDER ASSEMBLY (REVERSE JAW) 2616001

PART NO.	DESCRIPTION	QTY. REQ'D
001014	BALL BEARING ER-36I, 2-1/4"ID X 4.33"OD .0001 / .0003 FIT	2
009012	CAM FOLLOWER, 1/2-20 X 1-1/4"OD WITH HEX HOLE	1
069015	LOCKING ASSEMBLY, 50 X 57	2
1616122	SUPPORT, JAW BAR	1
1616131	FIXED JAW, 1 ST JAW CYLINDER	1
1616310	RETAINER, CAM	2
1616321	PULLEY, DRIVE	1
1616330	CAP, JAW CYLINDER PULLEY	1
1616342	SUPPORT, JAW BAR	1
2616120	JAW BLADE	1
2616130	JAW BLADE	1
2616140	JAW BLADE	1
2616160	SLEEVE, BEARING OPERATOR SIDE	1
2616281	GEAR, LEFT HAND	1
2616361	CAM, HALF FOLD DOUBLE DIGEST 1 ST JAW	1
2616380	BLADE, BACKING	1
2616390	BLADE, BACKING	1
2616400	BLADE, BACKING	1

DATE	SYM	REVISION RECORD	DR	CHK



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TOLERANCES
 UNLESS OTHERWISE SPECIFIED

DECIMAL	.01
FRACTIONAL	XX ± .005
HOLE DIA	± 1/22
ANGLE	± 1 Deg

WEB PRESS LLC
 701 EAST D ST., TACOMA, WA 98002

1ST JAW CYL. ASSY, DP 22 3/4
 XXXXXXXXX DWG NO. 2616001 REV A

DATE: 5/2/95

ATLAS FOLDER

OPTION: STANDARD JAW CYLINDER 2616001A2

PART NO.	DESCRIPTION	QTY. REQ'D
1616092	BAR, JAW	1
OPTION: STANDARD 1ST JAW, ARM 2616001A3		
1616083	ARM, CAM FOLLOWER, OPERATOR SIDE	1
OPTION: STANDARD JAW, FILLER 2616001A4		
1616421	FILLER, BEARING GEAR SIDE	1
OPTION: STANDARD 1ST JAW CYLINDER 2616001A5		
2616111	JAW CYLINDER	1
OPTION: 22-3/4 ATLAS DOUBLE PARALLEL 1ST JAW CYLINDER 2626001A1		
2626111	JAW CYLINDER, DOUBLE PARALLEL	1
2626140	FILLER BAR	1
OPTION: 22-3/4 ATLAS DOUBLE PARALLEL 1ST JAW CYLINDER 2626001A2		
009012	CAM FOLLOWER, 1-1/4"	1
2626130	TUCKER BLADE	1
1626012	ARM, CAM FOLLOWER	1
1626021	CARRIER, DOUBLE PARALLEL TUCKER BLADE	1
1626051	PLATE, TUCKER BLADE	1
1626092	BAR, JAW DOUBLE PARALLEL & DOUBLE DIGEST 1 ST FOLD	1
2626121	CAM, DOUBLE PARALLEL, 1 ST JAW GEAR SIDE	1
4626120	SPACER, TUCKER BLADE	2
4626130	SPACER, TUCKER BLADE	1
162150	PLATE, TUCKER	1
22-3/4 ATLAS DOUBLE DIGEST 1ST JAW CYLINDER ASSEMBLY 2636001A1		
2636111	1 ST JAW CYLINDER DOUBLE DIGEST	1
2636123	FILLER BAR	1

ATLAS FOLDER
22-3/4 ATLAS DOUBLE DIGEST 1st JAW CYLINDER ASSEMBLY
2636001A2

PART NO.	DESCRIPTION	QTY. REQ'D
009012	CAM FOLLOWER 1-1/4"	1
1616122	SUPPORT, JAW BAR	1
2616120	JAW BLADE	1
2616130	JAW BLADE	1
2616140	JAW BLADE	1
1616342	SUPPORT, JAW BAR	1
1616091	BAR, JAW	1
1616083	ARM, CAM FOLLOWER, OPERATOR SIDE	1
1616131	FIXED JAW, 1 st JAW CYLINDER	1

ATLAS FOLDER
22-3/4 ATLAS DOUBLE PARALLEL / DOUBLE DIGEST
1st JAW CYLINDER ASSEMBLY 2646001A1

PART NO.	DESCRIPTION	QTY. REQ'D
2636111	1 ST JAW CYLINDER DOUBLE DIGEST	1
2636123	FILLER BAR	1
2626140	FILLER BAR	1

22-3/4 ATLAS DOUBLE PARALLEL / DOUBLE DIGEST
1st JAW CYLINDER ASSEMBLY 2646001A2

009012	CAM FOLLOWER, 1-1/4"	2
2626130	TUCKER BLADE	1
1616122	SUPPORT, JAW BAR	1
2616120	JAW BLADE	1
2616130	JAW BLADE	1
2616140	JAW BLADE	1
1616342	SUPPORT, JAW BAR	1
1626021	CARRIER, DOUBLE PARALLEL TUCKER BLADE	1
1626051	PLATE, TUCKER BLADE	1
1616091	BAR, JAW	1
1626091	BAR, JAW, DOUBLE PARALLEL & DOUBLE DIGEST 1 ST JAW (SCP2)	1
1616131	FIXED JAW, 1 ST JAW CYLINDER	1
1616082	ARM, CAM FOLLOWER, OPERATOR SIDE	1
1626011	ARM, CAM FOLLOWER (SCP2)	1
2626121	CAM, DOUBLE PARALLEL, 1 ST JAW GEAR SIDE	1



QuarterFold Assemblies

ATLAS FOLDER
UNIVERSAL QUARTER FOLD ASSEMBLY 2657000

PART NO.	DESCRIPTION	QTY. REQ'D
001001	BALL BEARING ER-16, 1"ID X 2.0472"OD (LOW DRAG)	11
001018	BALL BEARING, 3/4" ID X 1.8504" OD (SEALED)	1
001040	BALL BEARING, RADIAL 15/35/11MM	2
001054	BALL BEARING, ER-16X, LOW DRAG (WEB GUIDE APPLICATION ONLY)	21
002005	ROLLER BEARING, 3-1/2 ID X 4 OD X 3/4 NDL WITH NEEDLE BEARING	1
005017	THRUST BEARING, 3/4"ID X 1-1/4"OD X 1/8" THK (OILITE)	2
006017	TAPPED BASE PILLOW BLOCK, 1"BORE	2
011004	OILITE BUSHING, 3/4" ID X 1" OD WITH FLANGE BUSHING	2
011043	OILITE BUSHING, 1-1/2" X 1-3/4" X 1" LONG	4
020017	TENSION SPRING, EXTENSION, 3/4"OD X .105"WIRE DIAMETER X 2" LONG	2
021055*	PLUNGER, HAND RETRACTABLE 3/8-16UNC	1
030032*	SNAP RING, .594" DIA. EXTERNAL	1
030033	SNAP RING 1.375" INTERNAL	2
031070	ROLL PIN 1/4 DIA X 1-1/2 LONG	8
032003	SET COLLAR, 1"ID X 1-5/8"OD	1
032005	SET COLLAR, 5/16"ID X 5/8"OD	4
032023	SET COLLAR, 2 PIECE STEEL, 3/4"ID X 1-3/4" OD	1
032032 **	SET COLLAR, 1"-8 THREAD	1
033023	HANDLE, ADJUSTABLE CLAMPING, 3/8-16UNC TAP	2
035060	SHOULDER BOLT, 3/4 X 1-1/4 LONG, WITH NYLOC	2
041002*	SWITCH, MICRO, BZE6-2RQ62	2
050041 ***	PLUG, SOCKET HEAD PIPE, 1/2"NPT	7
060030*	TIMING BELT, 3/8"P X 3/4"W X 54" LONG	1
060033	TIMING BELT, 1/2"P X 1"W X 60" LONG	2
060051	TIMING BELT, 1/2P X 1W X 66" LONG	1

* Location and/or quantity not indicated on drawing and/or parts list

** Note: Item has changed to **032011 Set Collar, 1-1/8" ID X 1-3/4" OD**

*** Note: Item no longer used in this application.

ATLAS FOLDER
UNIVERSAL QUARTER FOLD ASSEMBLY 2657000 CONTINUED

PART NO.	DESCRIPTION	QTY. REQ'D
061042	PULLEY, TIMING BELT 16T X ½" P X 1" W, WITH TAPER BUSHING	1
062021	TAPER BUSHING, 1" BORE	1
067040	GEAR, SPUR (BOSTON) 6.00 P.D. 8 D.P. 48T 1" BORE	1
069002	BRACKET, IDLER 3-1/8" SL	1
069004	IDLER SHAFT, 1" DIA X 3-1/8" SL	1
069022	FLANGE TIGHTENER, FIXED, ¾" ID UNC	1
069024	PULLEY, IDLER, 1" BORE X 1.25" WIDE, CROWNED	15
069025	TRANTORQUE 1" DIAMETER SHAFT, STD SERIES	1
090067*	LATCH, RUBBER	1
090083	GIB HEAD KEY, ¼" X ¼" X 1-3/4"	1
090175	TAPE, 1" X 88" LONG – (LOWER 4C)	4
090275	TAPE, ¾" W X 121-1/2" LONG	4
090291	BUMPER, RUBBER, #1487-W	2
422040	STUB SHAFT, DANCER ROLL	1
514650	WASHERS, PHENOLIC	1
711040 ***	WASHERS, PHENOLIC	2
1612520	STIFFENER, SHAFT	1
1617570	SLEEVE, ECCENTRIC CHOPPER	1
1617580	ECCENTRIC CHOPPER DIVE	1
1617660	SCREW, SIDE MOVEMENT	1
1617790	STOP, SIDE MOVEMENT	1
1617870	QUARTER FOLD LATERAL ADJUSTMENT	1
1617910	BRACKET, GUIDE	2
1617920	SPRING, PAPER DRAG	2
2612343*	SWITCHMOUNT, FOLDER	1
2617230	PULLEY PINCH ROLL QUARTER FOLD	1
2617662	CREEL, QUARTERFOLD	3
2617690	IDLER PIN QUARTER FOLD CREEL DRIVE	1
2617780	SHAFT, QUARTER FOLD SUPPORT	1
2617800	IDLER PULLEY NIP ROLL DRIVE	1
2617810	DRIVE PULLEY, NIP ROLL QUARTERFOLD	1
2617820	NIP ROLL, QUARTERFOLD (ATLAS)	1

* Location and/or quantity not indicated on drawing and/or parts list

*****Note: This item no longer used in this application.**

ATLAS FOLDER
UNIVERSAL QUARTER FOLD ASSEMBLY 2657000 CONTINUED

PART NO.	DESCRIPTION	QTY. REQ'D
2617830	STUD-BELT IDLER	1
2617930	GUIDES	2
2617940	NIP ROLL, QUARTERFOLD (ATLAS)	1
2617950	SHAFT, CREEL QUARTERFOLD	1
2657010	PLATE, SIDE, QUARTERFOLD OPERATOR SIDE	1
2657020	PLATE, SIDE, QUARTERFOLD GEAR SIDE	1
2657030	PLATE, CENTER, QUARTERFOLD FRONT	1
2657040	PLATE, CENTER, QUARTERFOLD BACK	1
2657050	SUPPORT, GEARBOX	1
2657060	CHOPPER, LEVER ARM	1
2657070	CHOPPER, ARM, QUARTERFOLD	1
2657080	ARM, PIVOT	2
2657091	ROD, ADJUSTING, PINCH ROLL	2
2657150	DRIVE, INTERMEDIATE HALF FOLD	1
2657180	BLADE, CHOPPER QUARTERFOLD	1
2657190	DRUM, BELT DRIVE	1
2657210	PULLEY	1
2657220	PULLEY, QUARTERFOLD CREEL DRIVE	1
2657250	MOUNT, IDLER PULLEY	1
2657260	PLATE, TOP	1
2657270	STOP BAR, QUARTERFOLD	1
2657290	PLATE, TOP, BACK	1
2657300	MOUNTING BAR, WEB GUIDE	2
2657310	ROLLER CORE	3
2657320	PLATE, TOP, FRONT	1
2657380	SHAFT, DRIVE BELT DRUM	1
2657400	MOUNT, PINCH ROLL ADJUSTING ROD	2
2657420	STUD, BELT IDLER	1
2657450	GUIDE, BLADE	1
2657460	GUIDE, MOUNTING BRACKET	2
2657470	GUIDE, BACK	4
2657480	SHAFT, HALF FOLD CREEL	1
2657500	BRACKET, IDLER PULLEY	4

ATLAS FOLDER
UNIVERSAL QUARTER FOLD ASSEMBLY 2657000 CONTINUED

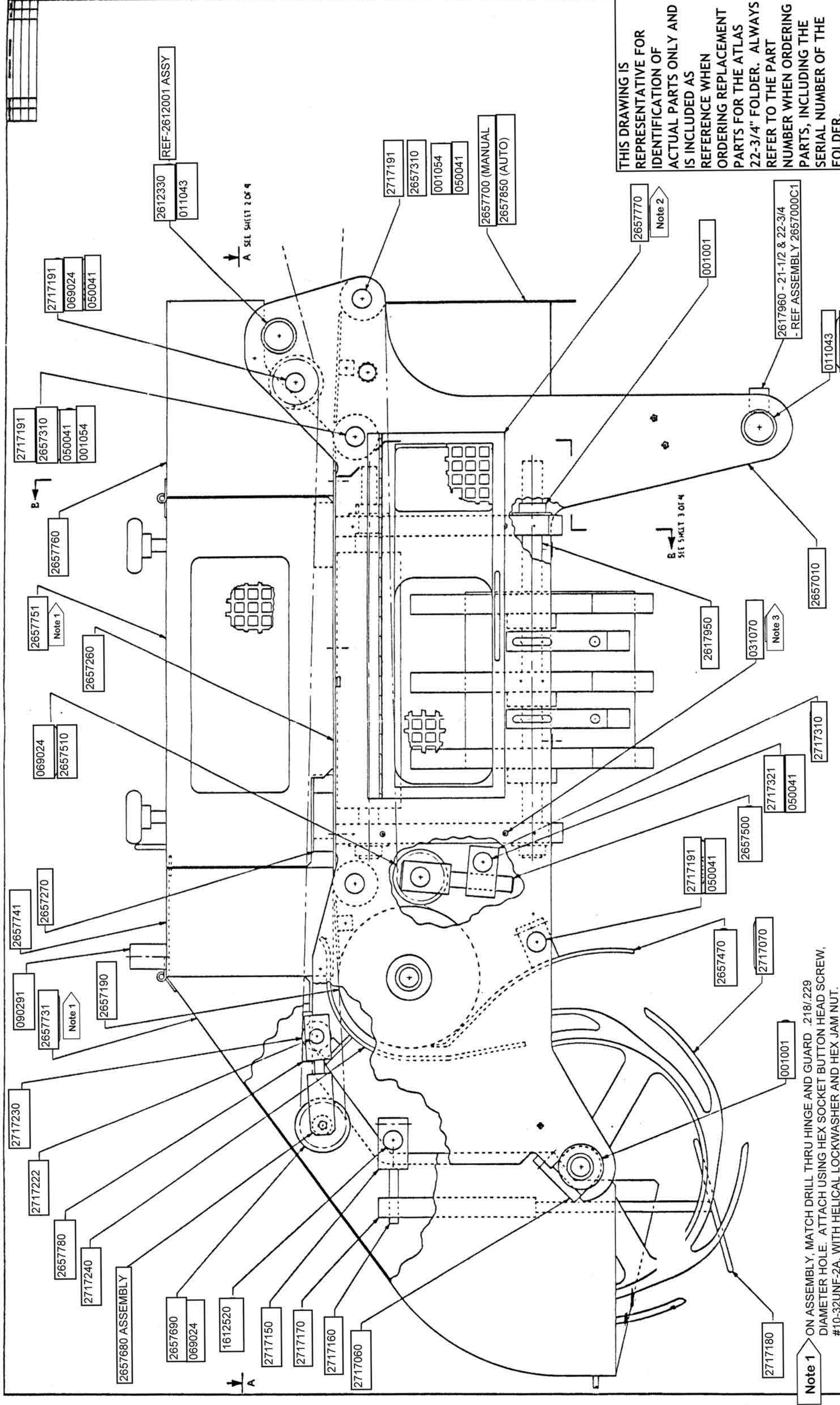
PART NO.	DESCRIPTION	QTY. REQ'D
2657510	SHAFT, IDLER PULLEY	4
2657530	SHAFT, CHOPPER ARM	1
2657570	GEAR, HALF FOLD CREEL	1
2657580	SHAFT	1
2657590	PULLEY, HUB	1
2657640	PLATE, GEARSHIFT LOCK	1
2657680	BELT ADJUSTMENT ASSEMBLY	4
2657690	STUD, IDLER	4
2657711	GUARD, HALF FOLD BELT	1
2657720	GUARD, GEAR BOX AND CHOPPER	1
2657731	GUARD, HALF FOLD CREEL	1
2657741	SUPPORT, CREEL GUARD	1
2657751	GUARD, CHOPPER	1
2657760	SUPPORT, CHOPPER GUARD	1
2657770	GUARD, QUARTERFOLD CREEL	1
2657780	RETAINER, UPPER TAPE SHAFT	2
2657820	KNOB, PINCH ROLL ADJUSTABLE	2
2657830*	BLOCK, GUIDE MOUNTING	1
2657840*	PLATE, CHOPPER BLADE	1
2657910*	STUD, IDLER (REFERENCE A1514-14)	1
2717060	CLAMP	2
2717070	CREEL	3
2717150	MOUNTING BLOCK, STRIPER ROD	2
2717160	MOUNTING ROD, STRIPPER GUIDE	2
2717170	HOLDER STRIPPER GUIDE	2
2717180	STRIPPER	2
2717191	SHAFT, MOUNTING	5
2717222	SHAFT	1
2717230	BRACKET, TOP GUIDE	4
2717240	GUIDE, TOP	4
2717310	BRACKET, BOTTOM BELT MOUNTING	4
2717321	SHAFT, BOTTOM TAPE TENSIONER	1

* Location and/or quantity not indicated on drawing and/or parts list

ATLAS FOLDER

UNIVERSAL QUARTER FOLD ASSEMBLY 2657000 CONTINUED

PART NO.	DESCRIPTION	QTY. REQ'D
3514010	SCREW, SPRING ADJUSTMENT	2
3514040	SCREW, SPRING ADJUSTMENT	2



THIS DRAWING IS REPRESENTATIVE FOR IDENTIFICATION OF ACTUAL PARTS ONLY AND IS INCLUDED AS REFERENCE WHEN ORDERING REPLACEMENT PARTS FOR THE ATLAS 22-3/4" FOLDER. ALWAYS REFER TO THE PART NUMBER WHEN ORDERING PARTS, INCLUDING THE SERIAL NUMBER OF THE FOLDER.

WEB PRESS LLC	701 EAST D ST. TACOMA, WA 98002
UNIVERSAL QUARTER FOLDER	
REV A	2657000 REV A SH 1 OF 4

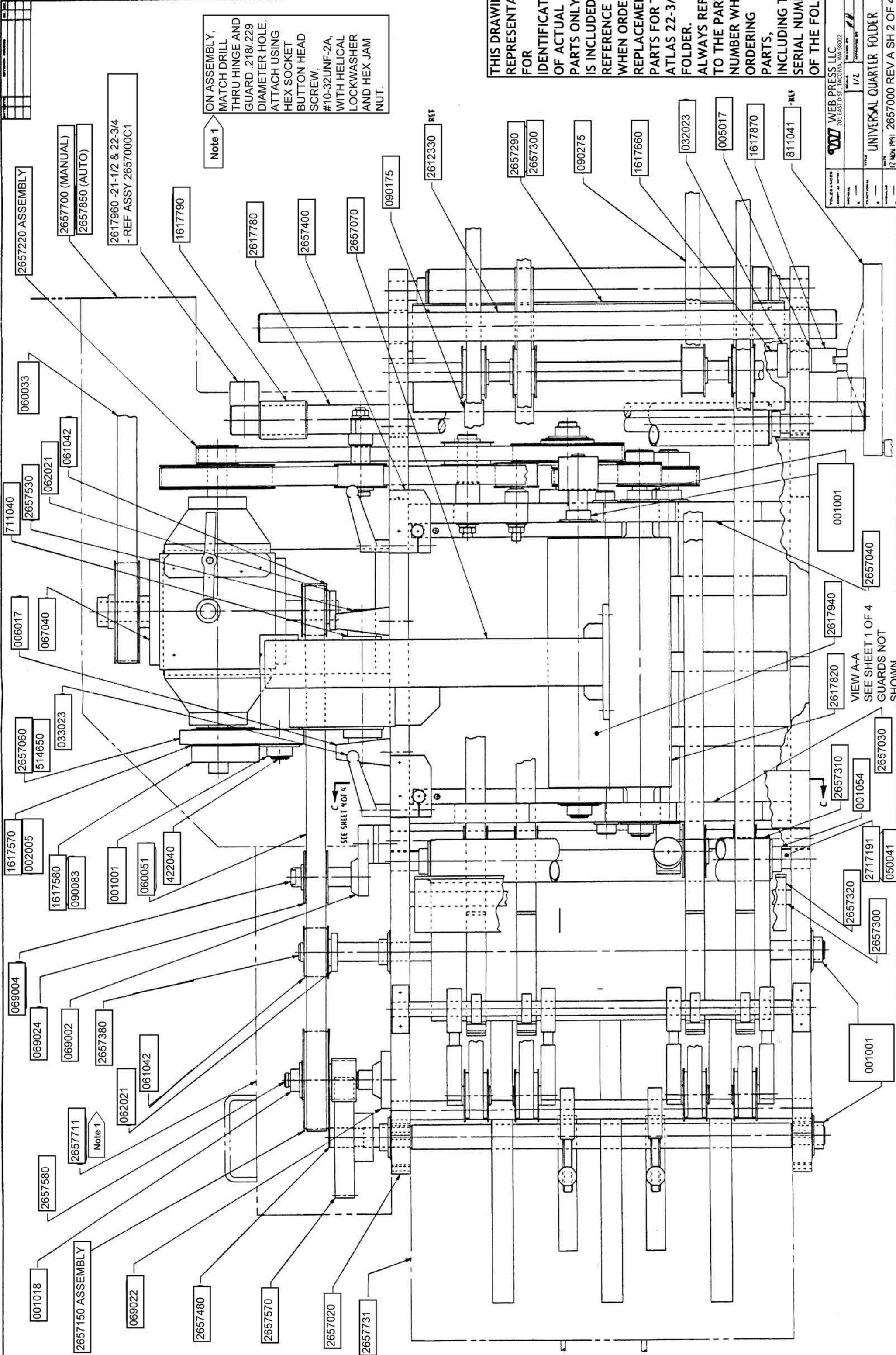
A SEE SHEET 2 OF 4

B SEE SHEET 3 OF 4

Note 3 USING 7/32" DIAMETER PILOT HOLE, MATCH DRILL .250/.256 DIAMETER HOLE X 1-3/4" DEEP. INSTALL ROLL PIN, 031070.

Note 1 ON ASSEMBLY, MATCH DRILL THRU HINGE AND GUARD .218/.229 DIAMETER HOLE. ATTACH USING HEX SOCKET BUTTON HEAD SCREW, #10-32UNF-2A, WITH HELICAL LOCKWASHER AND HEX JAM NUT.

Note 2 ON ASSEMBLY, MATCH DRILL THRU HINGE INTO SIDE FRAME, 2657010. TAP SIDEFRAME #10-32UNF-2B X5/8" DEEP. DRILL CLEARANCE HOLE .218/.229 DIAMETER IN HINGE. ATTACH USING HEX SOCKET BUTTON HEAD SCREW, #10-32UNF-2A, WITH HELICAL LOCKWASHER AND HEX JAM NUT.



Note 1
ON ASSEMBLY,
MATCH DRILL
THRU HINGE AND
GUARD .218/.229
DIAMETER HOLE,
ATTACH USING
HEX SOCKET
BUTTON HEAD
SCREW,
#10-32UNF-2A,
WITH HELICAL
LOCKWASHER
AND HEX JAM
NUT.

**THIS DRAWING IS
REPRESENTATIVE
FOR
IDENTIFICATION
OF ACTUAL
PARTS ONLY AND
IS INCLUDED AS
REFERENCE
WHEN ORDERING
REPLACEMENT
PARTS FOR THE
ATLAS 22-3/4"
FOLDER.
ALWAYS REFER
TO THE PART
NUMBER WHEN
ORDERING
PARTS,
INCLUDING THE
SERIAL NUMBER
OF THE FOLDER.**

TOLERANCES		WEB PRESS LLC 701 EAST D ST., TACOMA, WA 98002
FINISHES	SCALE	DATE
ASSEMBLY	1/2	1/2
DESCRIPTION	UNIVERSAL QUARTER FOLDER	
REV	17 NOV 1991 2657000 REV A SH 2 OF 4	

VIEW A-A
SEE SHEET 1 OF 4
GUARDS NOT
SHOWN

001001

2657300

2657310

2617820

2617940

2657040

001001

811041 -REF

1617870

005017

032023

1617660

090275

2657290
2657300

2612330 REF

090175

2657070

2657400

2617780

1617790

2617960 -21-1/2 & 22-3/4
- REF ASSY 2657000C1

2657700 (MANUAL)
2657850 (AUTO)

2657220 ASSEMBLY

050041

2717191

001054

2657030

2657320

001001

2657310

2617820

2617940

2657040

001001

000033

060033

711040

2657530

062021

061042

006017

067040

2657060

514650

033023

1617570

002005

1617580

090083

001001

060051

422040

069004

069024

069002

2657380

061042

062021

061042

2657580

2657711

062021

069022

2657480

001018

2657150 ASSEMBLY

2657570

2657020

2657731

2657570

2657020

2657731

2657570

2657020

2657731

2657570

001018

2657150 ASSEMBLY

2657570

2657020

2657731

2657570

2657020

2657731

2657570

2657020

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001018

2657150 ASSEMBLY

2657570

2657020

2657731

2657570

2657020

2657731

2657570

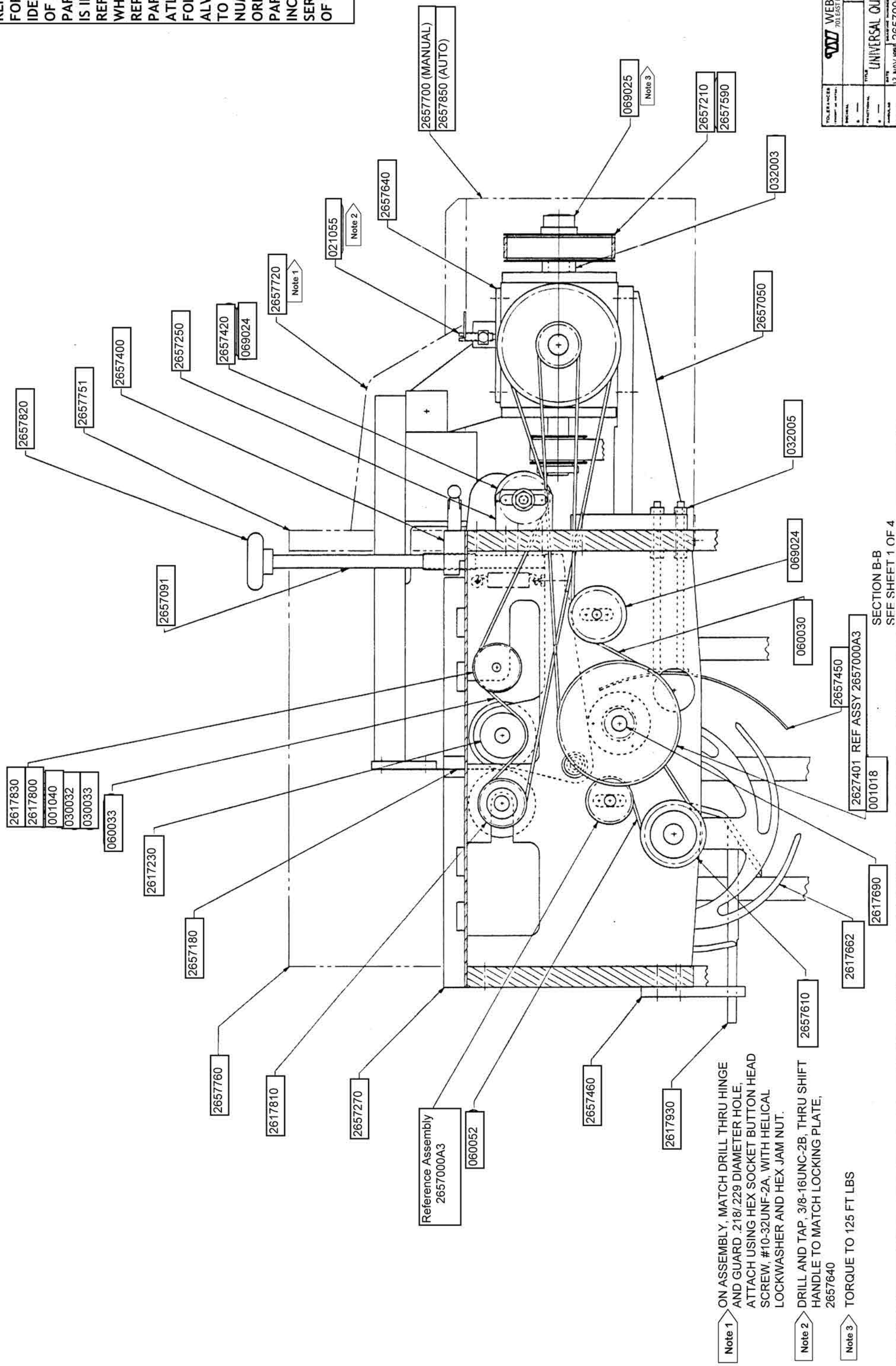
2657020

2657731

2657570

REV	DATE	DESCRIPTION

THIS DRAWING IS REPRESENTATIVE FOR IDENTIFICATION OF ACTUAL PARTS ONLY AND IS INCLUDED AS REFERENCE WHEN ORDERING REPLACEMENT PARTS FOR THE ATLAS 22-3/4" FOLDER. ALWAYS REFER TO THE PART NUMBER WHEN ORDERING PARTS, INCLUDING THE SERIAL NUMBER OF THE FOLDER.



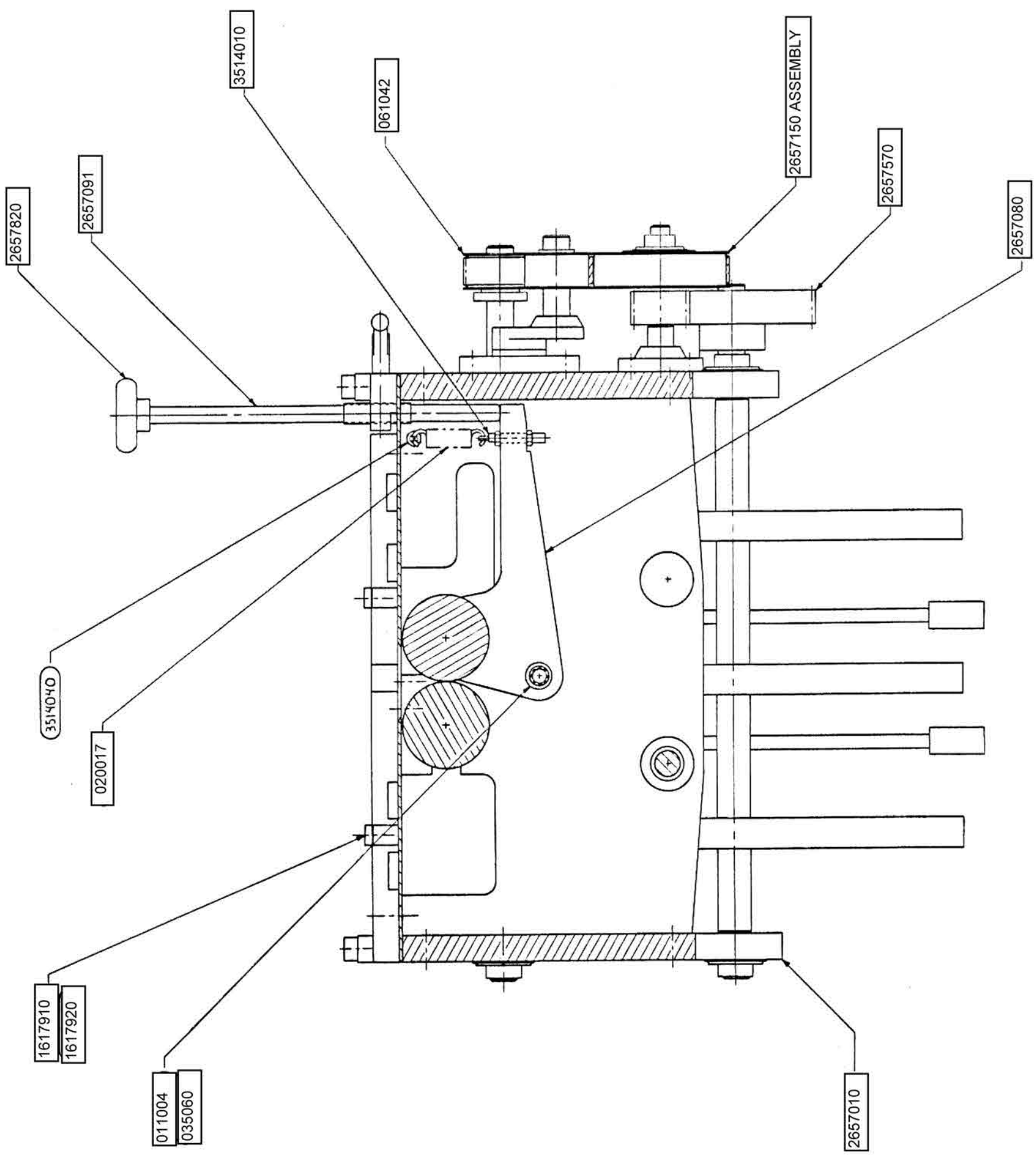
- Note 1 ON ASSEMBLY, MATCH DRILL THRU HINGE AND GUARD .218/.229 DIAMETER HOLE, ATTACH USING HEX SOCKET BUTTON HEAD SCREW, #10-32UNF-2A, WITH HELICAL LOCKWASHER AND HEX JAM NUT.
- Note 2 DRILL AND TAP, 3/8-16UNC-2B, THRU SHIFT HANDLE TO MATCH LOCKING PLATE. 2657640
- Note 3 TORQUE TO 125 FT LBS

WEB PRESS LLC 701 EAST 1ST ST., FACOMBA, WA 98002	
TITLE UNIVERSAL QUARTER FOLDER	DATE 12 NOV 1991
PARTIAL NO. 1/2	PARTIAL BY [Signature]
2657000 REV A SH 3 OF 4	

SECTION B-B
SEE SHEET 1 OF 4

THIS DRAWING IS REPRESENTATIVE FOR IDENTIFICATION OF ACTUAL PARTS ONLY AND IS INCLUDED AS REFERENCE WHEN ORDERING REPLACEMENT PARTS FOR THE ATLAS 22-3/4" FOLDER. ALWAYS REFER TO THE PART NUMBER WHEN ORDERING PARTS, INCLUDING THE SERIAL NUMBER OF THE FOLDER.

		WEB PRESS LLC 701 EAST ST., TACOMA, WA 98602	
FOLDER NUMBER 2657000	PART NUMBER 2657010	QUANTITY 1/2	DATE 12 NOV 1991
UNIVERSAL QUARTER FOLDER			
2657000 REV A SH 4 OF 4			



SECTION C-C
 SEE SHEET 2 OF 4
 GUARDS NOT SHOWN

ATLAS FOLDER
OPTION: STANDARD QUARTERFOLD CREEL 8 POCKET (STD)
2657000A3

PART NO.	DESCRIPTION	QTY. REQ'D
001018	BALL BEARING, ¾ ID X 1.8504 OD (SEALED)	1
060052	TIMING BELT, 3/8P X 3/4W X 18.7" LONG	1
2627401	QUARTERFOLD CREEL PULLEY ASSEMBLY	1
2627930	PULLEY, CREEL	1

OPTION: UNIVERSAL QUARTERFOLD REVERSE - CREEL 8 POCKET
2657000A4

001018	BALL BEARING, ¾ ID X 1.8504 OD (SEALED)	1
2617101	PULLEY, QUARTERFOLD ASSEMBLY	1
2617300	MOUNT, HUB	1
2617540	GEARA, SPUR	1

OPTION: 22-3/4" & 600MM QUARTERFOLD 2657000B1

061042	PULLEY, TIMING BELT, 16T X 1/2P X 1" W, WITH TAPER BUSHING, TYPE EF	1
062021	TAPER BUSHING, 1" BORE	1

OPTION: QUARTERFOLD GUARD, 22-3/4" 2657000C1

2617960*	BLOCK, MOUNTING	2
2657700**	GUARD, MAIN DRIVE BELT	1
2657850***	GUARD, MAIN DRIVE	1

OPTION: BRUSH ASSEMBLY –FOR BOOKSTOCK ONLY 2617001B

2717511	BRACKET, BRUSH MOUNT	2
2717520	BLOCK, SHAFT MOUNT	4
2717530	SHAFT, BRUSH MOUNT	1
2717540	BRUSH, QUARTERFOLD	4

- * Note: For Manual / Auto Folder
- ** Note: For Auto Folder (Older Models)
- *** Note: For Field Repair Only



Strippers & Guides

**ATLAS FOLDER
STRIPPERS AND GUIDES 2618001**

PART NO.	DESCRIPTION	QTY. REQ'D
075752**	STRIPPER, PICKER PIN	8
1618270	BAR, GUIDE MOUNTING	1
1618330	GUIDE BLADE	5
2618022	BRACKET, PICKER PIN STRIPPER	1
4618030*	MOUNTING, BLOCK	1
4618040	MOUNTING, BLOCK	2
4618061	GUIDE, STRIPPER	8
4618260	BLOCK, GUIDE MOUNTING	1
4618270	BLOCK, GUIDE MOUNTING	1

OPTION: DOUBLE PARALLEL FOLDER 2618001B

001054	BALL BEARING, ER-16X, LOW DRAG (WEB GUIDE APPLICATION ONLY)	2
1612260	ROLLER CORE	1
1618150****	BRACKET, STRIPPER BAR, 2 ND JAW	2
1618161	STRIPPER, 2 ND JAW CYLINDER	5
1618170	BAR, STRIPPER MOUNTING	1
1618190	STIFFENER, SHAFT	1
1618210***	BLOCK, GUIDE MOUNTING	2
1618220	BAR, GUIDE MOUNTING	1
1618230	BLADE, GUIDE	5
2618141*	BRUSH, DOUBLE PARALLEL	5
2618180	SUPPORT, IDLER ROLL	2
2618210	MOUNT, PAPER BRAKE	3
2618220	BRAKE, DOUBLE PARALLEL PAPER	3
4618080	BRACKET, BRUSH	1

OPTION: DOUBLE DIGEST FOLDER 2618001C

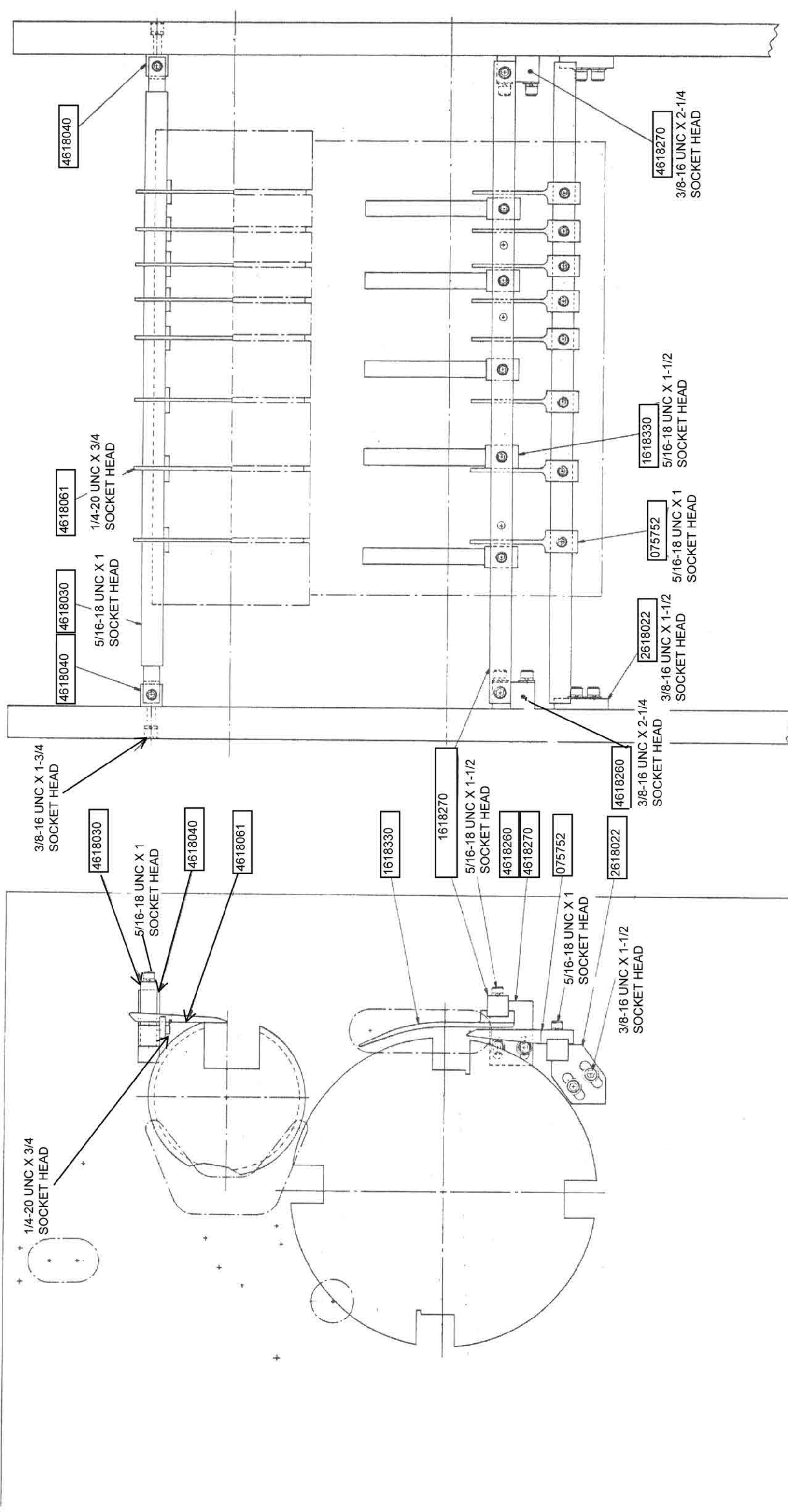
1618100	STRIPPER, PIN CYLINDER	8
1618140	SHAFT	1
2618240	BRACKET, DOUBLE DIGEST BRUSH ASSEMBLY	2
2618250	PLATE, DOUBLE DIGEST BRUSH MOUNTING	1
4618070	BRACKET, STRIPPER	2

* Note: For 1st Jaw Cylinder

** Note: For Pin Cylinder

*** Note: Pin Cylinder to 1st Jaw Cylinder

**** Note: 2nd Jaw Cylinder



1/4-20 UNC X 3/4
SOCKET HEAD

3/8-16 UNC X 1-3/4
SOCKET HEAD

4618030
5/16-18 UNC X 1
SOCKET HEAD

4618040

4618061

1618330

1618270
5/16-18 UNC X 1-1/2
SOCKET HEAD

4618260

4618270

075752

5/16-18 UNC X 1
SOCKET HEAD

2618022
3/8-16 UNC X 1-1/2
SOCKET HEAD

4618040

4618061
1/4-20 UNC X 3/4
SOCKET HEAD

4618030
5/16-18 UNC X 1
SOCKET HEAD

4618040

4618260
3/8-16 UNC X 2-1/4
SOCKET HEAD

075752
5/16-18 UNC X 1
SOCKET HEAD

1618330
5/16-18 UNC X 1-1/2
SOCKET HEAD

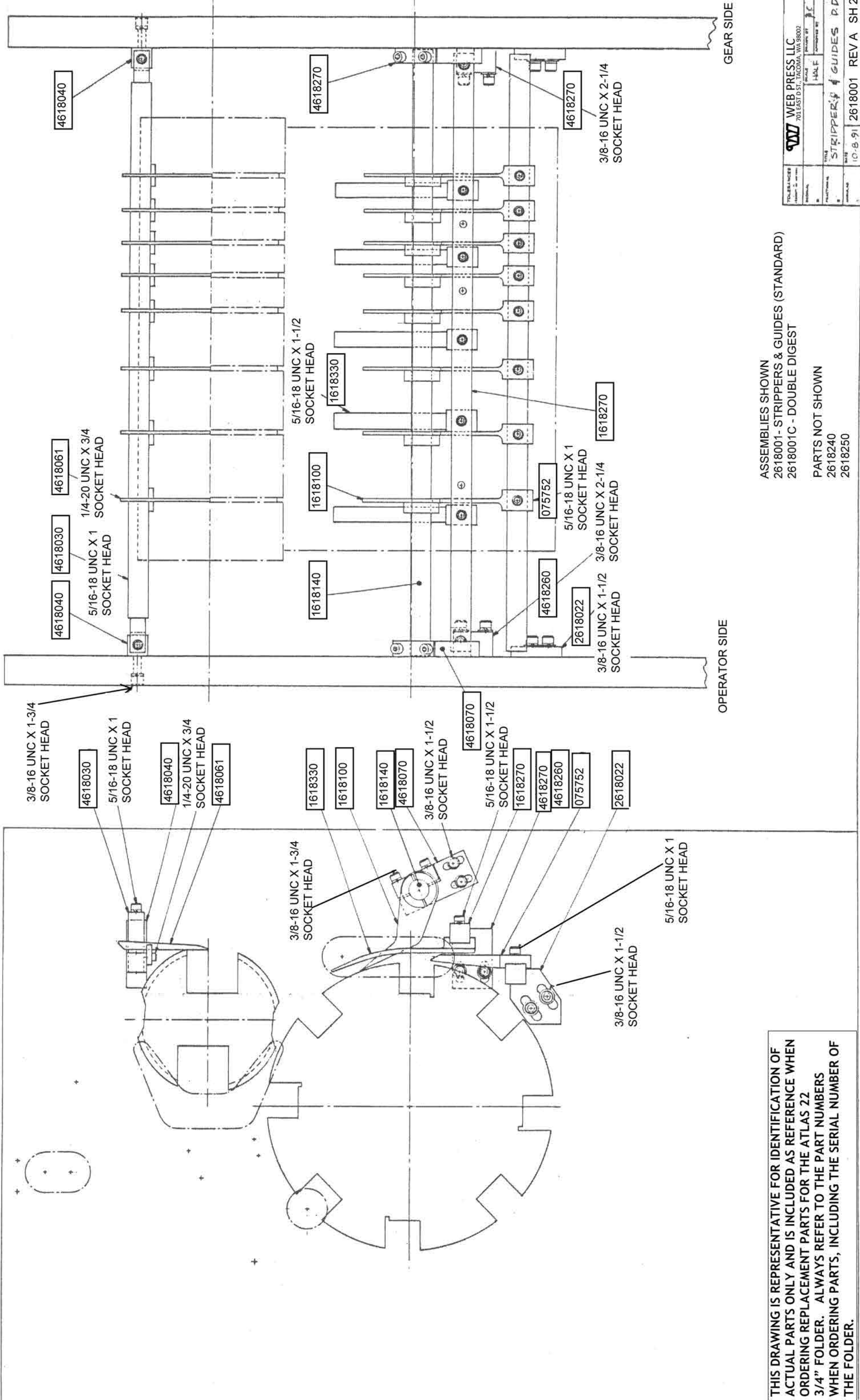
4618270
3/8-16 UNC X 2-1/4
SOCKET HEAD

OPERATOR SIDE

GEAR SIDE

THIS DRAWING IS REPRESENTATIVE FOR IDENTIFICATION OF ACTUAL PARTS ONLY AND IS INCLUDED AS REFERENCE WHEN ORDERING REPLACEMENT PARTS FOR THE ATLAS 22 3/4" FOLDER. ALWAYS REFER TO THE PART NUMBERS WHEN ORDERING PARTS, INCLUDING THE SERIAL NUMBER OF THE FOLDER.

DRAWING NUMBER		SCALE		DATE	
10-B-91		HALF		10-8-91	
REV A		SH 1 OF 4		REV A	
<p>WEB PRESS LLC 701 EAST D ST., TACOMA, WA 98602</p> <p>STRIPPERS & GUIDES, STD.</p>					



ASSEMBLIES SHOWN
 2618001 - STRIPPERS & GUIDES (STANDARD)
 2618001C - DOUBLE DIGEST

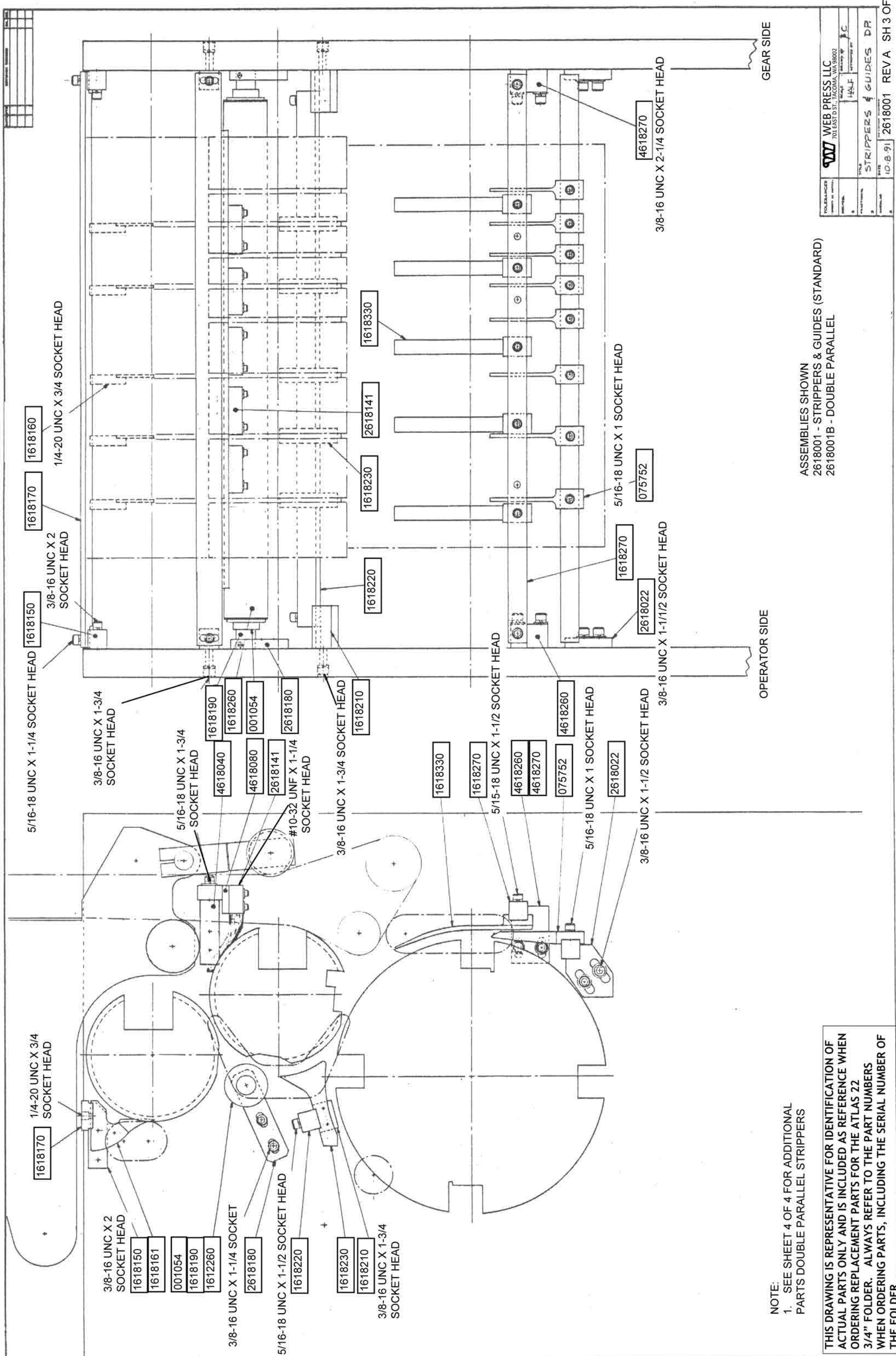
PARTS NOT SHOWN
 2618240
 2618250

THIS DRAWING IS REPRESENTATIVE FOR IDENTIFICATION OF ACTUAL PARTS ONLY AND IS INCLUDED AS REFERENCE WHEN ORDERING REPLACEMENT PARTS FOR THE ATLAS 22 3/4" FOLDER. ALWAYS REFER TO THE PART NUMBERS WHEN ORDERING PARTS, INCLUDING THE SERIAL NUMBER OF THE FOLDER.

WEB PRESS LLC
 701 EAST D ST., TACOMA, WA 98002

STEPPER GUIDES P.D.

10-B-91 2618001 REV A SH 2 OF 4



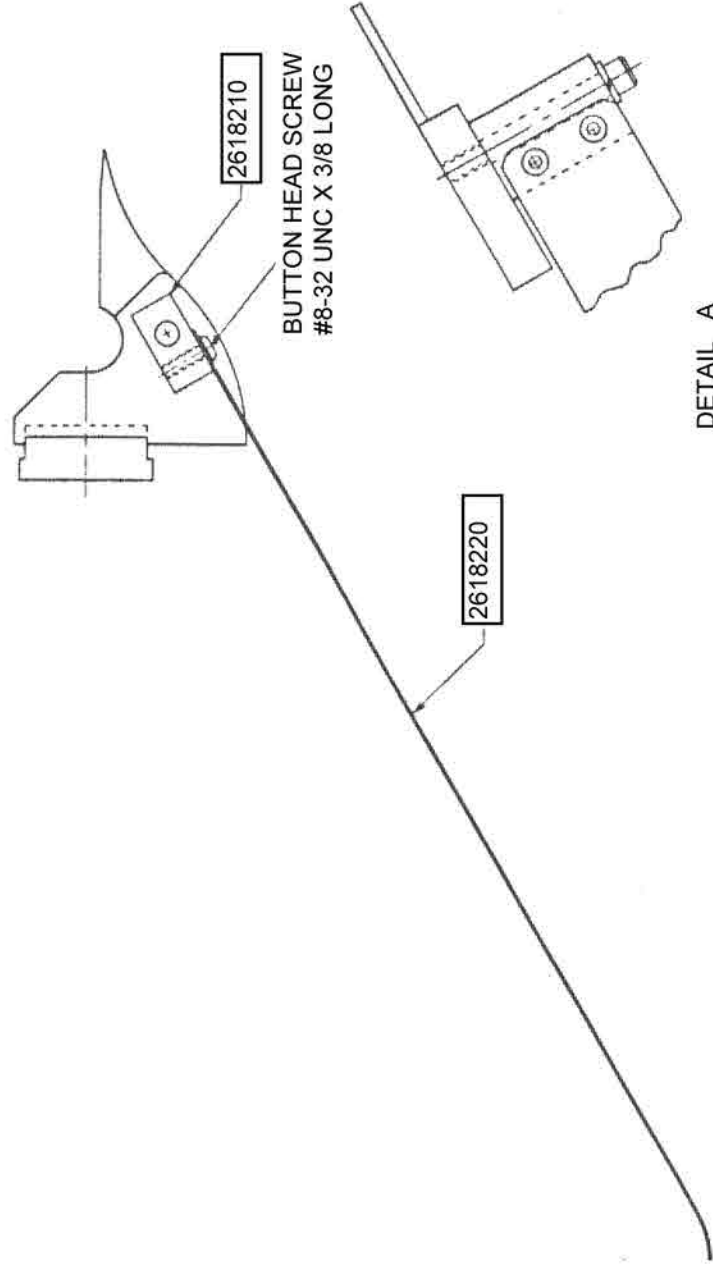
		WEB PRESS LLC 701 EAST D ST., PACOMA, WA 98002
DRAWING NO. 10-B-91	TITLE STRIPPERS & GUIDES DR.	DATE 2618001 REVA SH 3 OF 4
DESIGNED BY	CHECKED BY	APPROVED BY
DRAWN BY	DATE	SCALE

ASSEMBLIES SHOWN
 2618001 - STRIPPERS & GUIDES (STANDARD)
 2618001B - DOUBLE PARALLEL

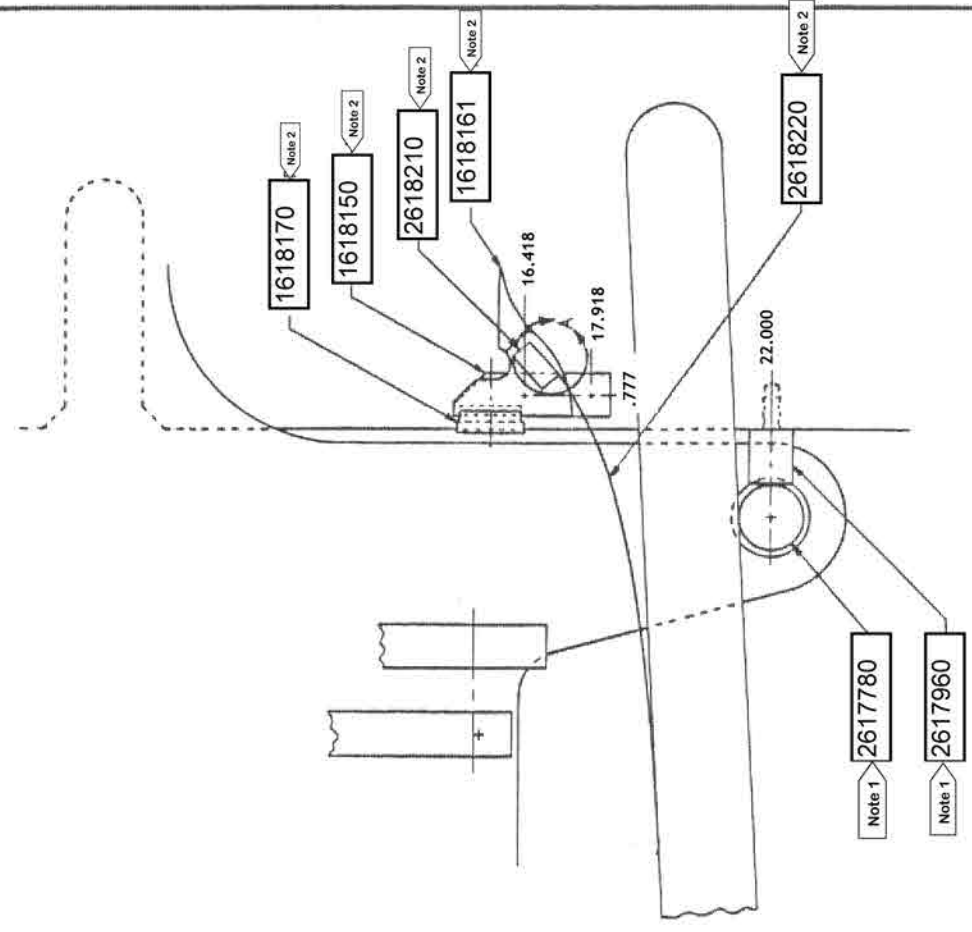
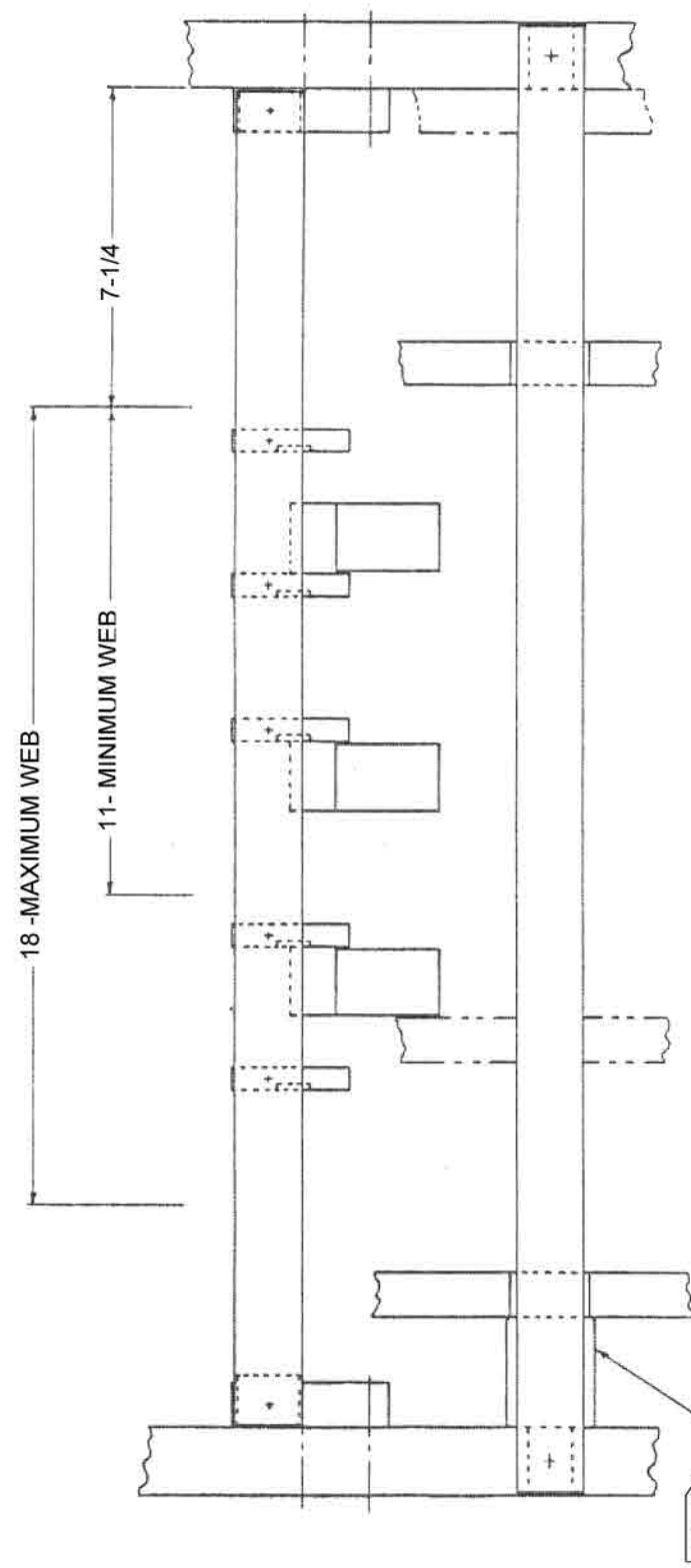
NOTE:
 1. SEE SHEET 4 OF 4 FOR ADDITIONAL PARTS DOUBLE PARALLEL STRIPPERS

THIS DRAWING IS REPRESENTATIVE FOR IDENTIFICATION OF ACTUAL PARTS ONLY AND IS INCLUDED AS REFERENCE WHEN ORDERING REPLACEMENT PARTS FOR THE ATLAS 22 3/4" FOLDER. ALWAYS REFER TO THE PART NUMBERS WHEN ORDERING PARTS, INCLUDING THE SERIAL NUMBER OF THE FOLDER.

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DETAIL A
SCALE: FULL



- NOTES:
1. REFERENCE ASSEMBLY 2657000
 2. REFERENCE ASSEMBLY 2618001B

ASSEMBLIES SHOWN
2618001 - STRIPPERS & GUIDES
2618001B - DOUBLE PARALLEL

WEB PRESS LLC 701 EAST D ST., TACOMA, WA 98002	
ATLAS FOLDER MODEL: 22 3/4 PART: 1/2	STRIPPER AND GUIDE, PF DATE: 17 JULY 1987 REV: 2618001



Guards

ATLAS FOLDER
GUARDS, 21-1/2 & 22-3/4 ATLAS FOLDER 2619001

PART NO.	DESCRIPTION	QTY. REQ'D
033004	KNOB, 3/4 OD -10-32X 1/2 LONG	1
090057	LATCH, MAGNETIC	3
090059	LATCH, RUBBER	1
090124	BUMPER, RUBBER	2
090143	DRAW CATCH	4
090157	STRIKE KEEPER, FOR 090143 DRAW CATCH	4
1612032	GUARD, FOLDER CLUTCH	1
1612140	GUARD, HALF FOLD, MAIN DRIVE	1
1612150	GUARD, HALF FOLD, MAIN DRIVE	1
1612161	GUARD, HALF FOLD, TOP	1
1612610	STAND-OFF	3
2527201	SPACER, LATCH	2
2619021	GUARD	1
2619030	GUARD, HALF FOLD OPERATOR SIDE	1
2619040	GUARD, HALF FOLD OPEARTOR SIDE	1
2619060	MOUNTING BRACKET, FOLDER OPERATOR SIDE	1
2619070	PLATE, FOLDER OPERATOR SIDE GUARD	2
2619090	HINGE, OPERATOR SIDE HALF FOLD GUARD	2
2619100	MOUNTING SHIM, QUARTERFOLD GUARD	1
2619110	MOUNTING BRACKET, OPERATOR SIDE FOLDER GUARD	1
2619120	RETAINER	2
2619450	GUARD, STAND-OFF	1
2619560	GUARD, QUARTERFOLD TO HR	1
OPTION: GUARDS – CONIC FORMER 2619001A6A		
2619550	GUARD, FRONT & BACK NIP	2
OPTION: CE GUARD SWITCH 2619001A6B		
041092*	RELAY, SAFETY	A/R
041091	SWITCH, PROXIMITY	10
453140	BRACKET, MICRO SWITCH MOUNT	1
517630	SPACER, 1/8" X 1" PLASTIC	8

*Note: One Required Per Press Line. Actual Quantity depends on number of units.

ATLAS FOLDER
OPTION: CE GUARD SWITCH 2619001A6B

(continued)

PART NO.	DESCRIPTION	QTY. REQ'D
517640	SPACER, 1/8" X 1-7/16"	12
517650	SPACER, 3/8" X 1"	2
517660	SPACER, 3/8" X 1-7/16"	2
517880	BRACKET, SWITCH MOUNT	1
11013230	SWITCH MOUNT	2

GUARDS 2619002

033004	KNOB, 3/4" OD 10-32 STUD X 1/2" LONG	2
090057	LATCH, MAGNETIC	2
090059	LATCH, RUBBER	1
090067 ***	LATCH, RUBBER	1
090124 ***	BUMPER, RUBBER	2
1612032	GUARD, FOLDER CLUTCH	1
1612140	GUARD, HALF FOLD MAIN DRIVE	1
1612150	GUARD, HALF FOLD MAIN DRIVE	1
1612161	GUARD, HALF FOLD TOP	1
2619022	GUARD, GEAR SIDE HEADROLL	1
2619120	RETAINER	2
2619290	GUARD, DOOR	1
2619520	COVER, 1 ST JAW HOLE	1
2619530	COVER, 2 ND JAW	1
2619540	COVER, PIN CYLINDER	1
2619560	GUARD, QUARTERFOLD TO HR	1

OPTION: STANDARD FOLDER 2619002A1

2619480*	CAP	1
2619490**	CAP	2

OPTION: FOLDER WITH OR WITHOUT MOTOR 2619002A2

090067	LATCH, RUBBER	1
2619471	GUARD, DR. 50/100 HP	1
2619501	GUARD, UPPER 50/100 HP	1

* Note: Not Required with DP Folder

** Note: Not Required with Cross Perforator

*** Note- No longer used

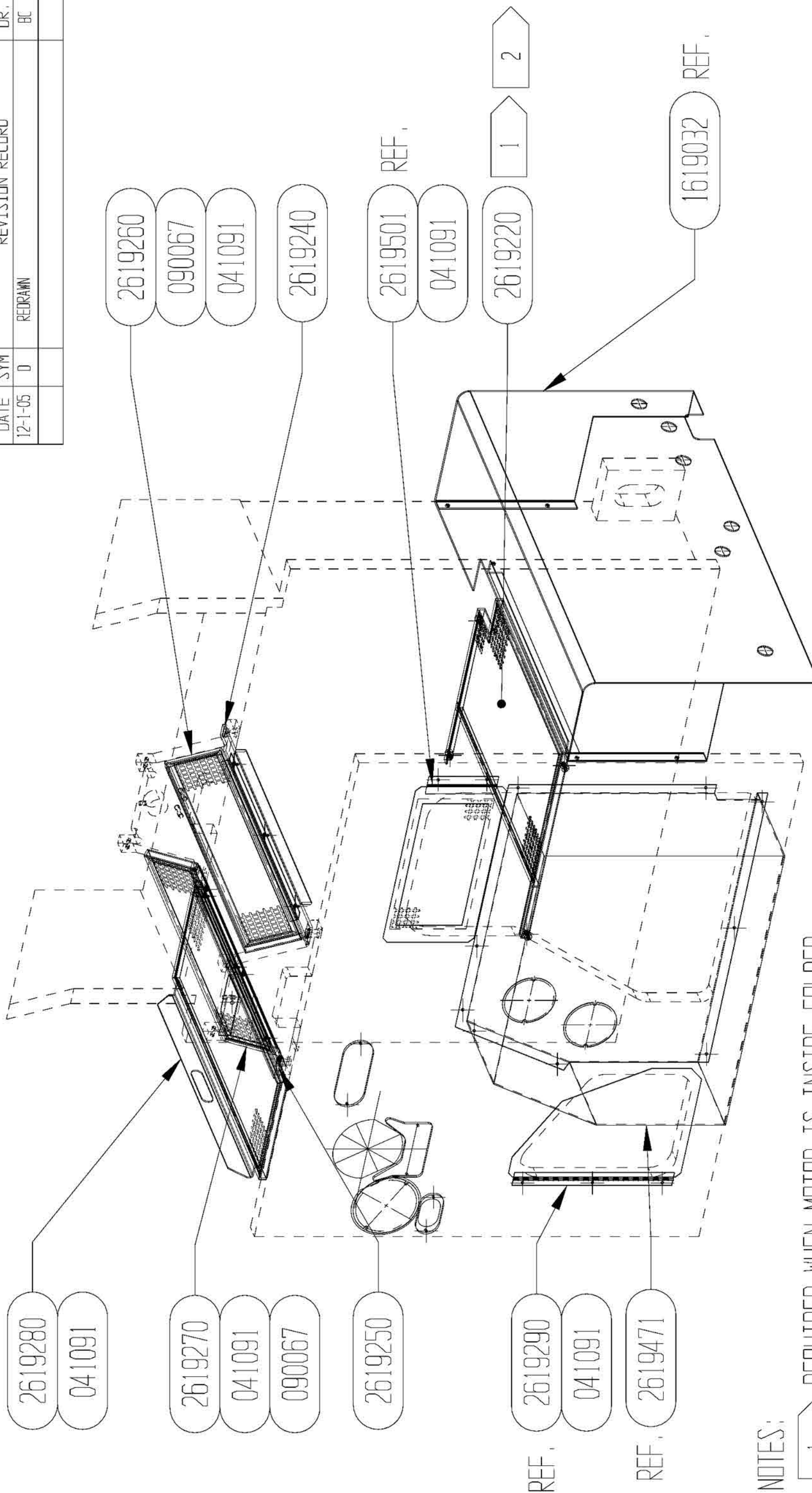
ATLAS FOLDER

OPTION: ATLAS FOLDER NIP GUARDS 2619001A6

PART NO.	DESCRIPTION	QTY. REQ'D
090067	LATCH, RUBBER	2
2619280	GUARD, HALF FOLD TAPES	1
2619250	MOUNT, NIP GUARDS, OPERATOR SIDE	1
2619270	GUARD, NIP ROLL, RIGHT HAND	1
2619240	MOUNT, NIP GUARDS, GEAR SIDE	1
2619220***	GUARD MOTOR	1
2619260	GUARD, NIP ROLL, LEFT HAND	1

*** Note: Required with Motor Only

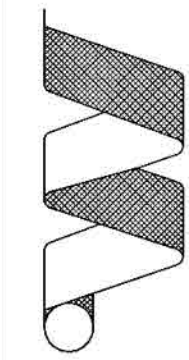

DATE	SYM	REVISION RECORD	DR.	CK.
12-1-05	D	REDRAWN	BC	



NOTES:

1 > REQUIRED WHEN MOTOR IS INSIDE FOLDER

2 > USE SPACERS, 1/2 O.D. X 9/32 I.D. X 1/2 LG.

				WEB PRESS LLC 701 EAST D ST., TACOMA, WA 98002	
TOLERANCES (EXCEPT AS NOTED)		TITLE NIP GUARDS, FOLDER		DWG NO. 2619001A6	
DECIMAL .XX ± .01 .XXX ± .005	FRACTIONAL ± 1/32	DRAWN BY BC.	SCALE XXXXX	DATE 11-30-05	SIZE B
ANGULAR ± 1 Deg	APPROVED BY XXXXXXXXXXXX	REV -0			

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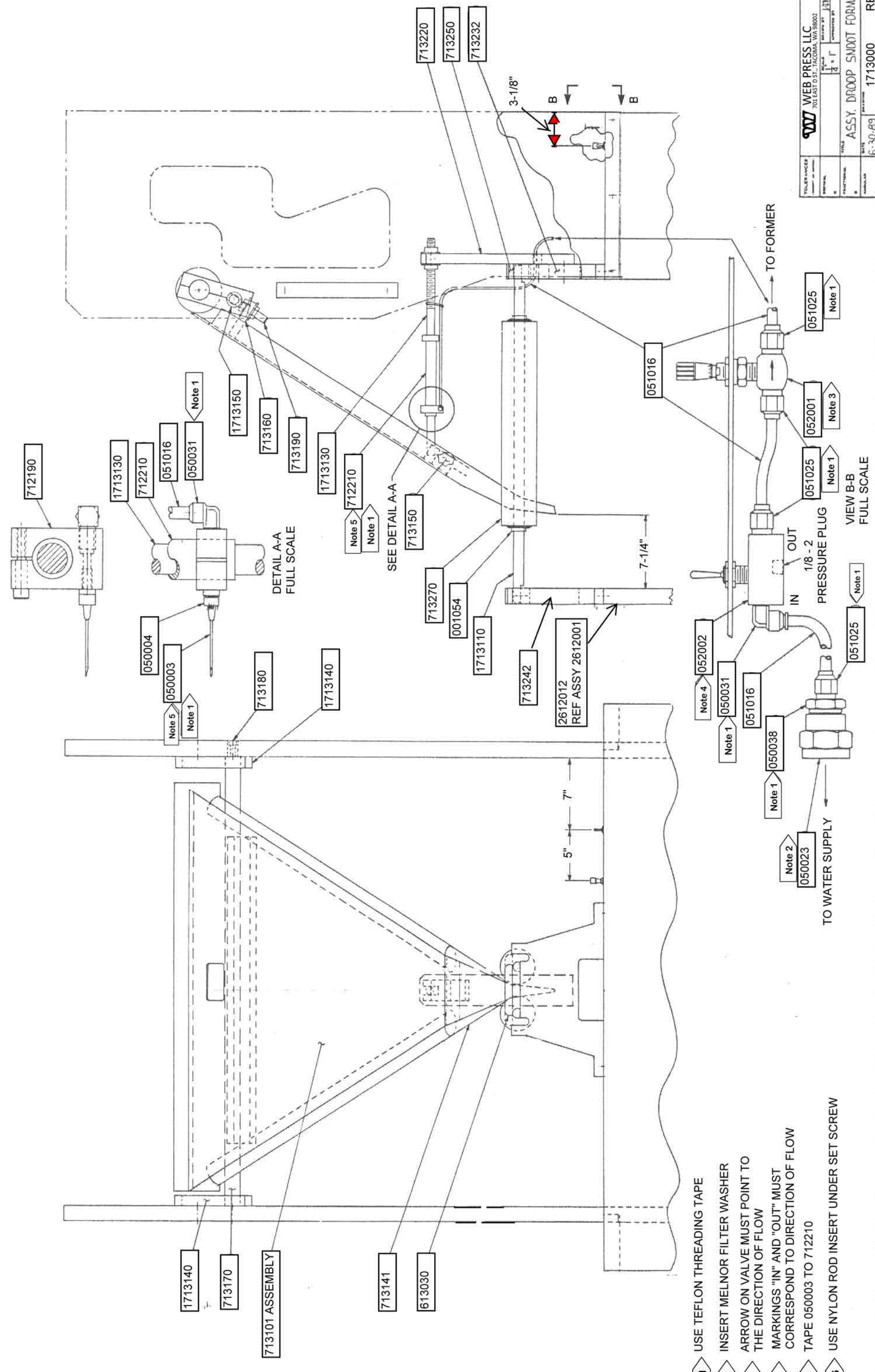


**Droop Snoot &
Conic Former Assemblies**

ATLAS FOLDER
DROOP SNOOT FORMER 1713000

PART NO.	DESCRIPTION	QTY. REQ'D
001054	BALL BEARING, ER-16X, LOW DRAG (WEB GUIDE APPLICATION ONLY)	4
050003	NEEDLE FITTING, WATER INJECTOR #18-1.5	2
050004	ADAPTER, NEEDLE, NYLON "PERFECTION" MALE	1
050023	ADAPTER, WATER HOSE	1
050031	ELBOW, MALE 1/8" NPT X 1/4" TUBE X 90°	2
050038	REDUCER, BUSHING 1/8" NPT X 1/2" NPT	1
051016	TUBING, PNEUMATIC, 1/4" OD, POLYETHELENE	7 FT
051025	MALE CONNECTOR, PNEUMATIC 1/4 X 1/8 NPT	4
052001	VALVE, HYDRAULIC PANEL MOUNT	1
052002	VALVE, MICRO, 2-WAY HYDRAULIC	1
613030	BRACKET, PRE-FORM ROLL	1
712190	BLOCK, WATER INJECTION SUPPORT	1
712210	TUBE ADJUST WATER INJECTION	1
713101	FORMER ASSEMBLY	1
713160	BAR, DROOP SNOOT FORMER	1
713170	SHAFT, FORMER MOUNTING	1
713180	BOSS, MOUNTING SHAFT	1
713190	SCREW, FORMER MOUNTING	2
713220	PLATE, BAR ANCHOR	1
713232	PLATE, DROOP SNOOT RISER, GEAR SIDE	1
713242	PLATE, DROOP SNOOT RISER, OPERATOR SIDE	1
713250	BRACKET, GEAR SIDE, PRE-FORM ROLL	1
713270	ROLLER, DROOP SNOOT FORMER	2
1713110	SHAFT, FORMING ROLL	2
1713130	ROD, FORMER ADJUSTMENT	1
1713140	BRACKET, FORMERBOARD MOUNT	2
1713150	SLEEVE, FORMERBOARD CENTERING	2

DATE	BY	REVISION



- Note 1 USE TEFLON THREADING TAPE
- Note 2 INSERT MELNOR FILTER WASHER
- Note 3 ARROW ON VALVE MUST POINT TO THE DIRECTION OF FLOW
- Note 4 MARKINGS "IN" AND "OUT" MUST CORRESPOND TO DIRECTION OF FLOW
- Note 5 TAPE 050003 TO 712210
- Note 6 USE NYLON ROD INSERT UNDER SET SCREW

TOLERANCES	UNLESS OTHERWISE SPECIFIED	WEB PRESS LLC
FINISHES	AS SHOWN	701 EAST ST. TACOMA, WA 98002
DRAWN	JTB	DATE
CHECKED	JTB	BY
APPROVED	JTB	DATE
TITLE	ASSY. DROOP SMOOT FORMER	PROJECT
SCALE	1:1	1713000
DATE	6-30-89	REV A

VIEW B-B
FULL SCALE

DETAIL A-A
FULL SCALE

SEE DETAIL A-A

2612012
REF ASSY 2612001

TO WATER SUPPLY

TO FORMER

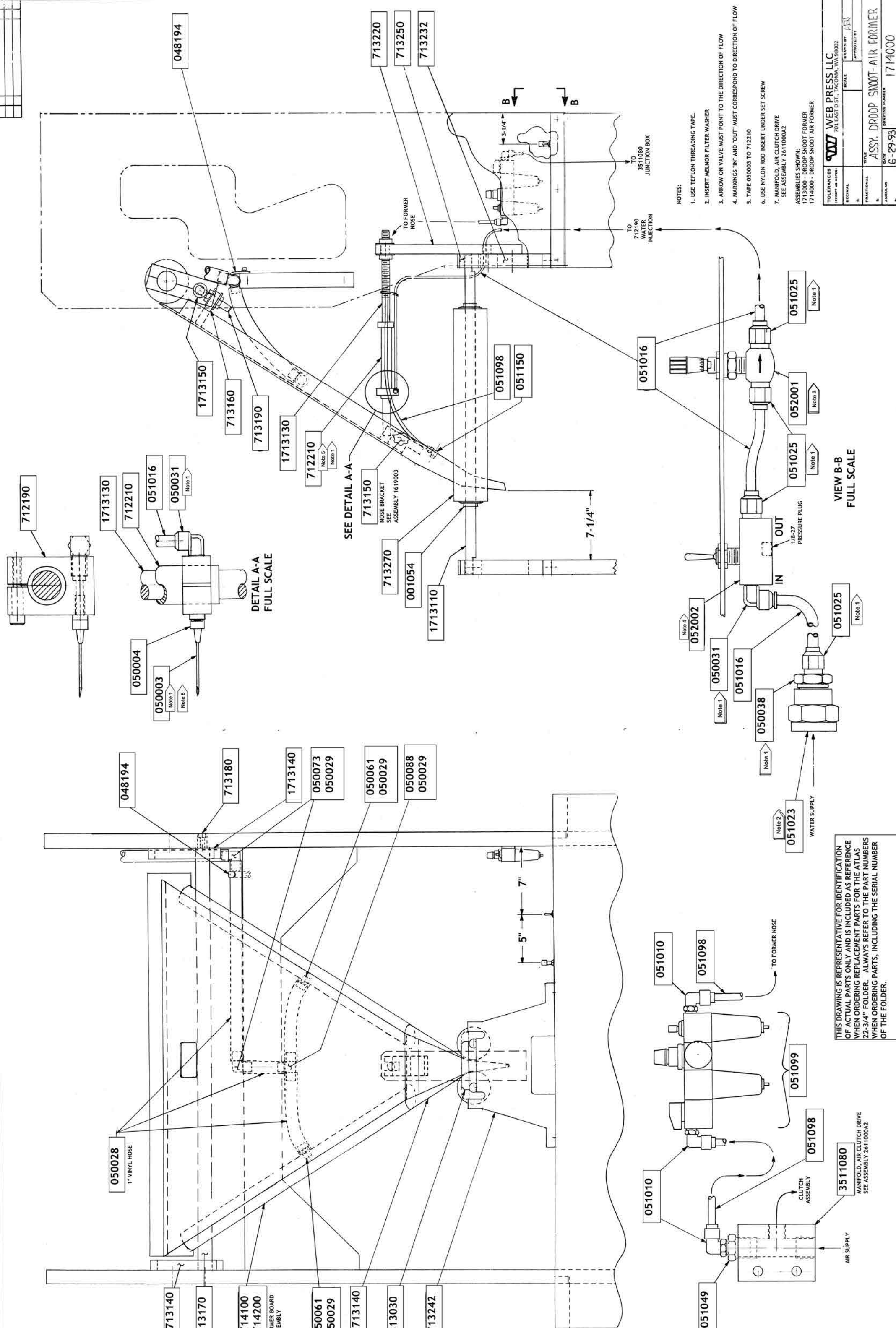
ATLAS FOLDER
DROOP SNOOT AIR FORMER 1714000

PART NO.	DESCRIPTION	QTY. REQ'D
001054	BEARING, ER-16X	4
048194	STRAP, 1" ONE-HOLE	1
050003	NEEDLE, WATER INJECTION #118-1.5	2
050004	ADAPTER, NEEDL	1
050023	ADAPTER, WATER HOSE	1
050029	HOSE CLAMP 1", 5 X 444	8
050031	ELBOW, MALE, 1/8" NPT X 1/4" X 90°	2
050038	REDUCER BUSHING, 1/8" X 1/2" NPT	1
050061	HOSE ADAPTER, 3/4" PIPE X 1" BARB	2
050073	ELBOW, 90°, 1" X 1" BARB/ NYLON	2
050088	TEE, BARB, 1"X1"X1"	1
051010	ELBOW, SWIVEL, 1/4" NPT X 1/4" T	3
051016	TUBING, POLYETHYLENE, 1/4" OD	7 FT
051025	CONNECTOR, MALE, 1/4" T X 1/8 NPT	4
051049	BUSHING, MALE/FEMALE, 3/8" X 1/4" NPT	1
051098	TUBING, 1/8" X 1/4" OD	20 FT
051099	FILTER/REGULATOR/LUBE	1
051150	ELBOW, SWIVEL	2
052001	VALVE, PANEL MOUNT	1
052002	VALVE, 2-WAY MICRO	1
1713110	SHAFT, FORMING ROLL	2
1713130	ROD, FORMER ADJUSTING	1
1713140	BRACKET, FORMERBOARD MOUNT	2
1713150	SLEEVE, FORMERBOARD CENTERING	2
1714100	AIR FORMER ASSEMBLY	1
613030	BRACKET, PRE-FORM ROLL	1
712190	SUPPORT BLOCK, WATER INJECTION	1
712210	TUBE, WATER INJECTION ADJUSTMENT	1
713170	SHAFT, FORMER MOUNTING	1
713180	BOSS, MOUNTING SHAFT	1
713190	SCREW, FORMER MOUNTING	2
713220	PLATE, BAR ANCHOR	1

ATLAS FOLDER
DROOP SNOOT AIR FORMER 1714000

CONTINUED

PART NO.	DESCRIPTION	QTY. REQ'D
713232	PLATE, DROOP SNOOT RISER, GEAR SIDE	1
713242	PLATE, DROOP SNOOT RISER, OPERATOR SIDE	1
713250	BRACKET, PRE-FORM ROLLER, GEAR SIDE	1
713270	ROLLER, DROOP SNOOT FORMER	2



WEB PRESS LLC 701 EAST D ST., TACOMA, WA 98602	
TOLERANCES (EXCEPT AS NOTED)	SCALE
DIMENSIONAL	GRAPHIC BY <i>JEN</i>
FRACTIONAL	APPROVED BY
ANGULAR	DATE 6-29-93
TITLE ASSY. DROOP SMOOT-AIR FORMER	DRAWING NUMBER 1714000

THIS DRAWING IS REPRESENTATIVE FOR IDENTIFICATION OF ACTUAL PARTS ONLY AND IS INCLUDED AS REFERENCE WHEN ORDERING REPLACEMENT PARTS FOR THE ATLAS 22-3/4" FOLDER. ALWAYS REFER TO THE PART NUMBERS WHEN ORDERING PARTS, INCLUDING THE SERIAL NUMBER OF THE FOLDER.

MANIFOLD, AIR CLENCH DRIVE
SEE ASSEMBLY 2611000A2

ATLAS FOLDER
CONIC AIR FORMER ASSEMBLY 1712002

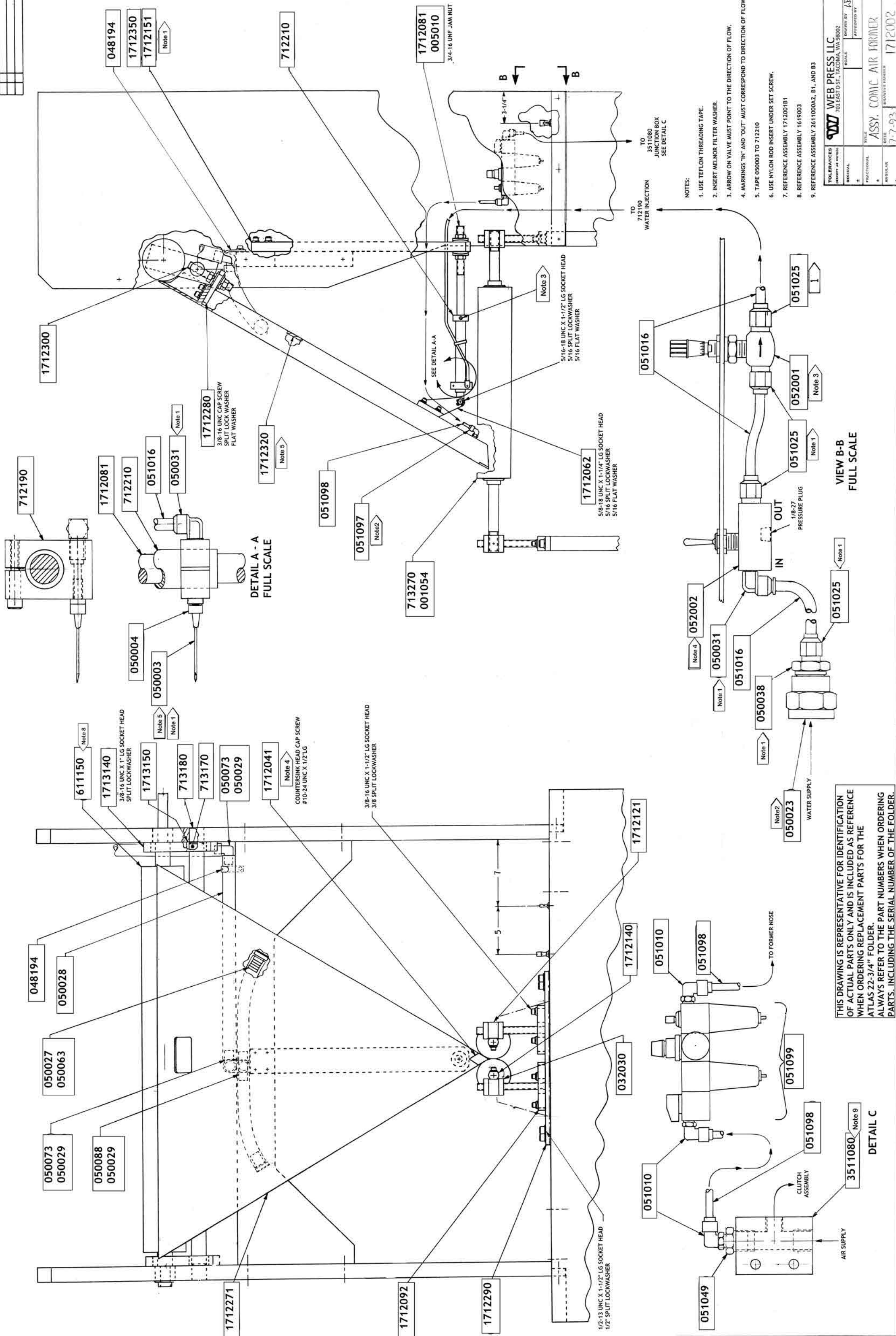
PART NO.	DESCRIPTION	QTY. REQ'D
001054	BEARING, ER-16X	4
005010	WASHER, SPHERICAL	2
032030	SET COLLAR, THREADED 3/4-16	8
048194	STRAP, 1" ONE-HOLE	1
050003	NEEDLE, WATER INJECTION #18-1.5	1
050004	ADAPTER, NEEDLE	1
050023	APAPTER, WATER HOSE	1
050027	PIPE, 1" SCREWED X 1" HOSE BARB PVC	2
050028	HOSE, VINYL, 1"	120 FT
050029	HOSE CLAMP, 1", 5 X 444	8
050031	ELBOW, MALE 1/8"NPT X 1/4" X 90°	2
050038	REDUCER, BUSHING 1/8" X 1/2 NPT	1
050063	HOSE CLAMP, 1-3/4" X 5" X 445	1
050073	ELBOW, 90°, 1" X 1" BARB NYLON	2
050088	TEE, BARB, 1" X 1" X 1"	1
051010	ELBOW, SWIVEL, 1/4" NPT X 1/4" T	3
051016	TUBING, POLYETHYLENE, 1/4" OD	7 FT
051025	CONNECTOR, MALE, 1/4" T X 1/8" NPT	4
051049	BUSHING, MALE/FEMALE, 3/8" X 1/4" NPT	1
051097	ELBOW, SWIVEL, 1/8" NPT X 1/4" TUBE	1
051098	TUBING, 1/8" X 1/4" OD	20 FT
051099	FILTER, REGULATOR, LUBE	1
052001	VALVE, PANEL MOUNT	1
052002	VALVE, MICRO, 2-WAY	1
613010	ROLLER, PRE-FORM	2
712190	SUPPORT BLOCK, WATER INJECTION	1
712210	TUBE, WATER INJECTION ADJUST	1
713170	SHAFT, FORMER MOUNTING	1
713180	BOSS, MOUNTING SHAFT	1
1712041	FORMER NOSE (CONIC)	1
1712062	BRACKET, AIR FORMER MOUNTING	1
1712081	ROD, CONIC AIR FORMER ADJUSTING	1

ATLAS FOLDER
CONIC AIR FORMER ASSEMBLY 1712002

CONTINUED

PART NO.	DESCRIPTION	QTY. REQ'D
1712092	RISER, CONIC AIR FORMER	4
1712121	COLLAR, FORMER ROLL STAND	4
1712271	AIR FORMER, CONIC	1
1712280	BRACKET, MOUNTING, CONIC AIR FORMER	2
1712290	ADAPTER, CONIC AIR RISER	2
1712300	SCREW, CONIC AIR FORMER ADJUSTING	2
1713140	BRACKET, FORMERBOARD MOUNTING	2
1713150	SLEEVE, FORMERBOARD CENTERING	2

DATE	REVISION	RECORD



- NOTES:
1. USE TEFLON THREADING TAPE.
 2. INSERT MELNOR FILTER WASHER.
 3. ARROW ON VALVE MUST POINT TO THE DIRECTION OF FLOW.
 4. MARKINGS "IN" AND "OUT" MUST CORRESPOND TO DIRECTION OF FLOW.
 5. TAPE 050003 TO 712210
 6. USE NYLON ROD INSERT UNDER SET SCREW.
 7. REFERENCE ASSEMBLY 1712001B1
 8. REFERENCE ASSEMBLY 1619003
 9. REFERENCE ASSEMBLY 2611000AZ, B1, AND B3

TOLERANCES UNLESS OTHERWISE SPECIFIED		WEB PRESS LLC 701 EAST D ST., FACONIA, WA 99002	
FRONT VIEW	SCALE	DESIGNED BY	(AB)
ISOMETRIC		APPROVED BY	
FUNCTIONAL		DATE	7-7-93
ASSEMBLY		DRAWING NUMBER	1712002

THIS DRAWING IS REPRESENTATIVE FOR IDENTIFICATION OF ACTUAL PARTS ONLY AND IS INCLUDED AS REFERENCE WHEN ORDERING REPLACEMENT PARTS FOR THE ATLAS 22-3/4" FOLDER. ALWAYS REFER TO THE PART NUMBERS WHEN ORDERING PARTS, INCLUDING THE SERIAL NUMBER OF THE FOLDER.

DETAIL C

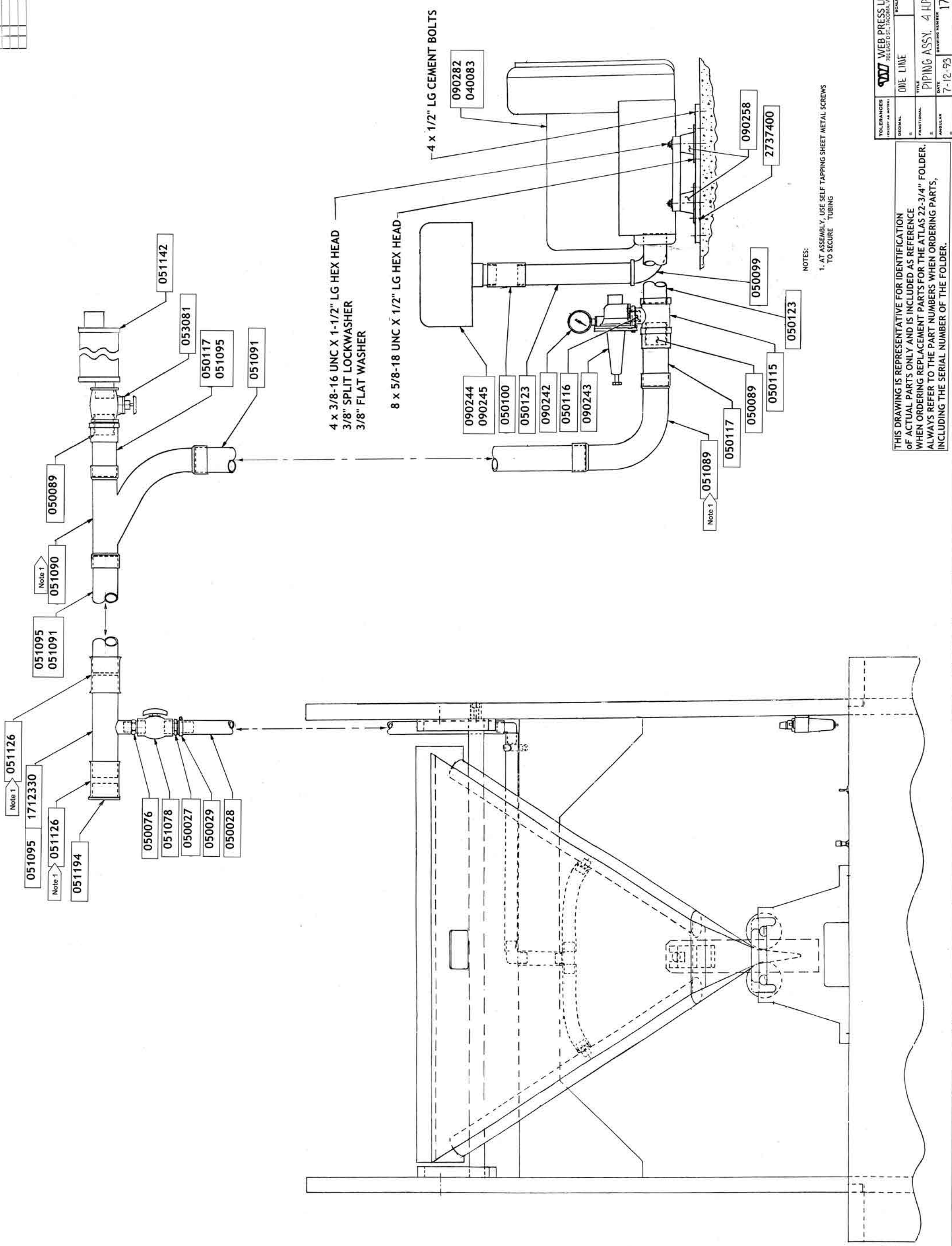
VIEW B-B
FULL SCALE

DETAIL A - A
FULL SCALE

ATLAS FOLDER
OPTION: PIPING ASSEMBLY 4 HP CONIC AIR FORMER ASSEMBLY
1712001A1

PART NO.	DESCRIPTION	QTY. REQ'D
040083	STARTER	1
050027	PIPE, 1" SCREWED X 1" HOSE BARB PVC	1
050028	HOSE, VINYL, 1"	120 FT
050029	HOSE CLAMP, 1", 5 X 444	1
050061	ADAPTER, HOSE, 3/4" PIPE X 1" BARB	1
050063	HOSE CLAMP, 1-3/4", 4 X 445	2
050076	NIPPLE, 1" X 3/4"	1
050089	NIPPLE 2" X 2" MNPT	2
050099	ELBOW, STREET, 2" 90°	1
050100	COUPLING, 2" SCHEDULE 40	2
050115	TEE, 2" X 2" X 1" FNPT	1
050116	NIPPLE, 1" X 1" MNPT	1
050117	FITTING, SLIP, 2"FNPT X 2-1/2" OD	2
050123	NIPPLE, 12" NPPT X 10" LG	2
051078	BALL VALVE, 1" PVC PIPE	1
051089	ELBOW, 90°	1
051090	TY, 90°, 2-1/2"OD, 16 GAUGE	1
051091	TUBING, MECHANICAL, 2-1/2" OD	240 FT
051095	HANGER, TUBING, 2-1/2" OD, 16 GAUGE	5
051126	COUPLING, SLIP, 2-1/2" X 3-1.2"	2
051142	MUFFLER M20	1
051194	PLUG, TUBE, 2-1/2"OD X 1-3/8"	1
053081	VALVE, GATE, 2" NPT, BRONZE	1
090242	GAUGE, PRESSURE	1
090243	VALVE, RELIEF	1
090244	COVER, FILTER	1
090245	ELEMENT, FILTER	1
090258	ISOLATOR, FLOOR MOUNT	4
090282	BLOWER, 4 HP	1
1712330	MANIFOLD, AIR	1
2737400	BRACKET, FLOOR BLOWER MOUNT	2

DATE	REV	DESCRIPTION



4 x 3/8-16 UNC X 1-1/2" LG HEX HEAD
3/8" SPLIT LOCKWASHER
3/8" FLAT WASHER

8 x 5/8-18 UNC X 1/2" LG HEX HEAD

4 x 1/2" LG CEMENT BOLTS

NOTES:
1. AT ASSEMBLY, USE SELF TAPPING SHEET METAL SCREWS TO SECURE TUBING

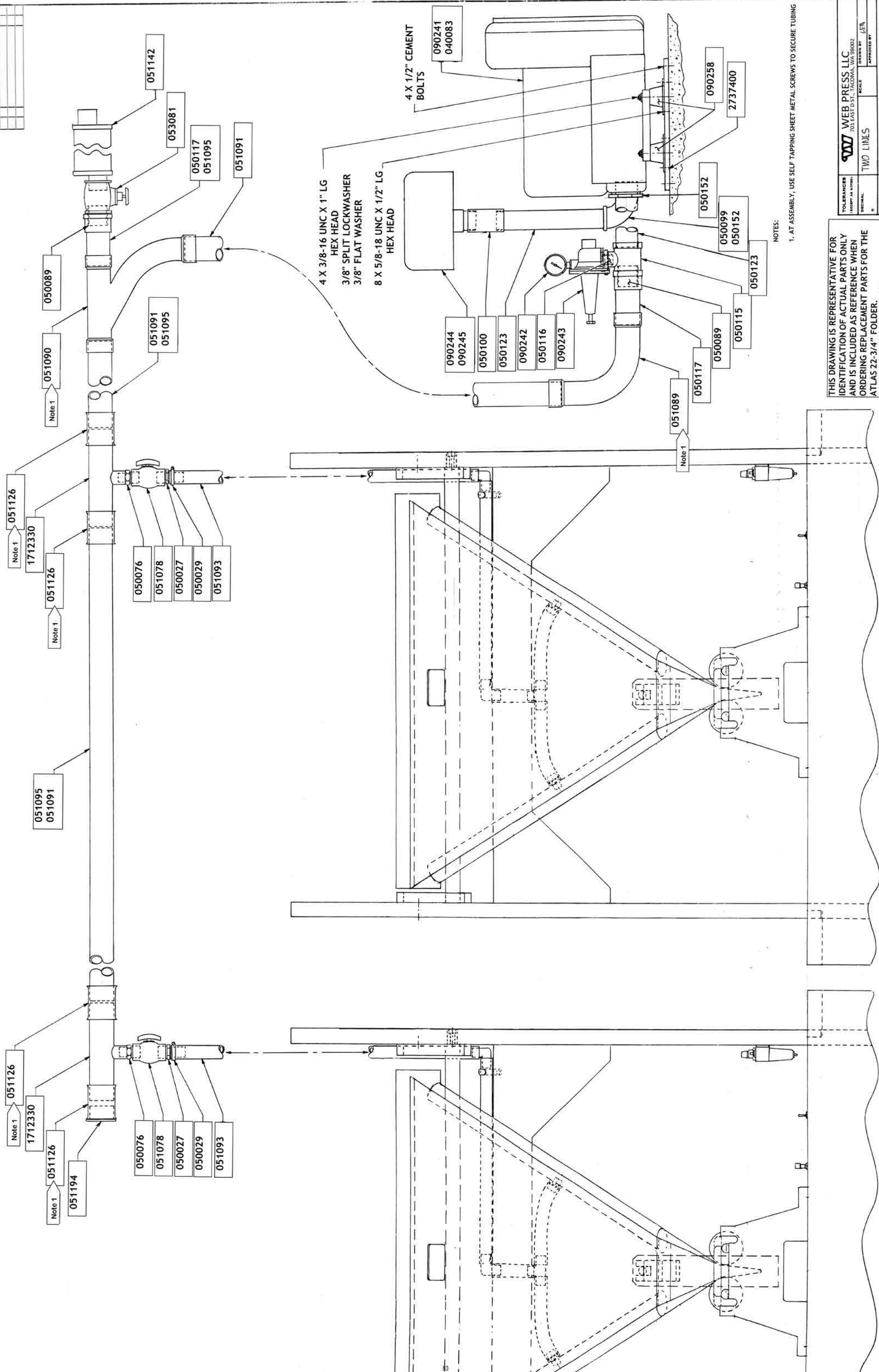
TOLERANCES UNLESS OTHERWISE SPECIFIED	WEB PRESS LLC 70 EAST ST., TACOMA, WA 98402
DECIMAL	DRAWN BY (AB)
FRACTIONAL	APPROVED BY
ANGULAR	TITLE PIPING ASSY. 4 HP. COMIL DROOP SHEET
DATE	7-12-93
DRAWING NUMBER	171200JA1

THIS DRAWING IS REPRESENTATIVE FOR IDENTIFICATION OF ACTUAL PARTS ONLY AND IS INCLUDED AS REFERENCE WHEN ORDERING REPLACEMENT PARTS FOR THE ATLAS 22-3/4" FOLDER. ALWAYS REFER TO THE PART NUMBERS WHEN ORDERING PARTS, INCLUDING THE SERIAL NUMBER OF THE FOLDER.

ATLAS FOLDER
OPTION: PIPING ASSEMBLY 5 HP CONIC AIR FORMER ASSEMBLY
1712001A2

PART NO.	DESCRIPTION	QTY. REQ'D
040083	STARTER	1
050027	PIPE, 1" SCREWED X 1" HOSE BARB PVC	2
050028	HOSE, VINYL, 1"	240 FT
050029	HOSE CLAMP, 1", 5 X 444	2
050061	ADAPTER, HOSE, 3/4" PIPE X 1" BARB	1
050063	HOSE CLAMP, 1-3/4", 5 X 445	4
050076	NIPPLE, 1" X 3/4"	2
050089	NIPPLE, 2" X 2" MNPT	2
050099	ELBOW, 90° STREET, 2"	1
050100	COUPLING, 2", SCHEDULE 40	1
050115	TEE, 2" X 2" X 1" FNPT	1
050116	NIPPLE, 1" X 1" MNPT	1
050117	FITTING, SLIP, 2" FNPT X 2-1/2" OD	2
050123	NIPPLE, 2" NPPT X 10" LG	2
050152	REDUCER, 2-1/2" NPT X 2" NPT	2
051078	BALL VALVE, 1" PVC PIPE	2
051089	ELBOW, 90°	1
051090	TY, 90°, 2-1/2" OD, 16 GAUGE	1
051091	TUBING, MECHANICAL, 2-1/2" OD	480 FT
051095	HANGER, TUBING, 2-1/2" OD, 16 GAUGE	7
051126	COUPLING, SLIP, 2-1/2" X 3-1/2"	4
051142	MUFFLER, M20	1
051194	PLUG, TUBING, 2-1/2" OD X 1-3/8"	1
053081	VALVE, GATE, 2" NPT, BRONZE	1
090241	BLOWER, 5 HP	1
090242	GAUGE, PRESSURE	1
090243	VALVE, RELIEF	1
090244	COVER, FILTER	1
090245	ELEMENT, FILTER	1
090258	ISOLATOR, FLOOR MOUNT	4
1712330	MANIFOLD, AIR	2
2737400	BRACKET, FLOOR BLOWER MOUNTING	2

DATE	
REVISED	
BY	
FOR	



NOTES:
1. AT ASSEMBLY, USE SELF TAPPING SHEET METAL SCREWS TO SECURE TUBING

THIS DRAWING IS REPRESENTATIVE FOR IDENTIFICATION OF ACTUAL PARTS ONLY AND IS INCLUDED AS REFERENCE WHEN ORDERING REPLACEMENT PARTS FOR THE ATLAS 22-3/4" FOLDER. ALWAYS REFER TO THE PART NUMBERS WHEN ORDERING PARTS, INCLUDING THE SERIAL NUMBER OF THE FOLDER.

TOLERANCES UNLESS AS NOTED		
DRAWN BY	TWO LINES	SCALE
CHECKED BY		APPROVED BY
FRACTIONAL		
DECIMAL		
ANGULAR		

WEB PRESS LLC 701 EAST 10 ST., TACOMA WA 98402	
TITLE	PIPING ASSY. 5 H.P. CONIC SUBOPT
DATE	7-9-93
DRAWING NUMBER	1712001A2

ATLAS FOLDER
OPTION: PIPING ASSEMBLY 10 HP CONIC AIR FORMER ASSEMBLY
1712001A3

PART NO.	DESCRIPTION	QTY. REQ'D
040084	STARTER	1
050027	PIPE, 1" SCREWED X 1" HOSE BARB PVC	3
050028	HOSE, 1" VINYL	380 FT
050029	HOSE CLAMP, 1", 5 X 444	3
050076	NIPPLE, 1" X 3/4"	3
050089	NIPPLE, 2" X 2" MNPT	1
050116	NIPPLE, 1" X 1" MNPT	1
050117	FITTING, SLIP, 2" FNPT X 2-1/2" OD	1
050121	NIPPLE, 2-1/2" NPT X 10" LG	2
050122	COUPLING, 2-1/2" X 2-1/2"	1
051078	BALL VALVE, 1" PVC PIPE	3
051089	ELBOW, 90°	1
051090	TY, 90°, 2-1/2 OD, 16 GAUGE	1
051091	TUBING, MECHANICAL, 2-1/2OD	630 FT
051095	HANGER, TUBE, 2-1/2" OD, 16 GAUGE	10
051096	ADAPTER, MALE, 2-1/2" -1/2"T	1
051126	COUPLING, SLIP, 2-1/2" X 3-1/2"	5
051131	TEE, 2-1/2" X 2-1/2" X 1" FNPT	1
051132	ELBOW, 90°, 2-1/2" X 2-1/2" FNPT	1
051142	MUFFLER, M20	1
051194	PLUG, TUBE, 2-1/2" OD X 1-3/8"	1
052041	NIPPLE, CLOSE, 2-1/2" X 2-1/2"	1
053081	VALVE, GATE, 2" NPT, BRONZE	1
090207	BLOWER, 10 HP, 290 S CFM 3.5 PSIG	1
090242	GAUGE, PRESSURE	1
090243	VALVE, RELIEF	1
090248	ELEMENT, FILTER	1
090257	FILTER	1
090258	ISOLATOR, FLOOR MOUNT	4
1712330	MANIFOLD, AIR	3
2737370	BLOWER MOUNT-ANGLE BAR PACKAGE	2

ATLAS FOLDER
OPTION: ATLAS FOLDER 1712001B1

PART NO.	DESCRIPTION	QTY. REQ'D
1712140	SHAFT, PRE-FORM ROLLER, HALF FOLD	2
1712151	SUPPORT, CONIC AIR FORM-ROD	1



Counter Assembly

**ATLAS FOLDER
COUNTER ASSEMBLY 1730001**

PART NO.	DESCRIPTION	QTY. REQ'D
041055	SWITCH, PROXIMITY P/N NB85-18GM50-EO	1
1730012	COUNTER PICK UP	1
1730032	BRACKET, PROXIMITY SWITCH	1

REFERENCE ASSEMBLY DRAWING 2614001, KNIFE CYLINDER ASSEMBLY



Auto Lubrication Systems

ATLAS FOLDER
ATLAS FOLDER AUTO LUBICATION 1833000

PART NO.	DESCRIPTION	QTY. REQ'D
051051	PLUG, PNEUMATIC, ¼" MALE HEX HEAD	1
051063	NIPPLE, PNEUMATIC HEX, S.S. ¼"NPT X ¼"NPT	1
053017	TUBE, 3/8"OD STEEL	A/R
053018	TUBE, STEEL, 1/8"OD	8 FT
053024	CLAMP, CLAMP, 1/8" STEEL	5
053026	CLAMP, TUBE 3/8"	A/R
053028	INJECTOR, SL-32 SERIES	1
053030	BALL VALVE, ¼" NPT S.S.	1
053032	CONNECTOR, MALE, 3/8T X ¼"NPT	1
053034*	ELBOW, FEMALE, 5/8"T X ¼"NPT	
053043	PLUG, CLOSURE	1
053054*/~	CONNECTOR, MALE 3/8"T X ¼"NPTF	
053056*	CONNECTOR, MALE 3/8T X ½"NPTF	
053058*	ELBOW, FEMALE 5/8"OD X ½"NPTF	

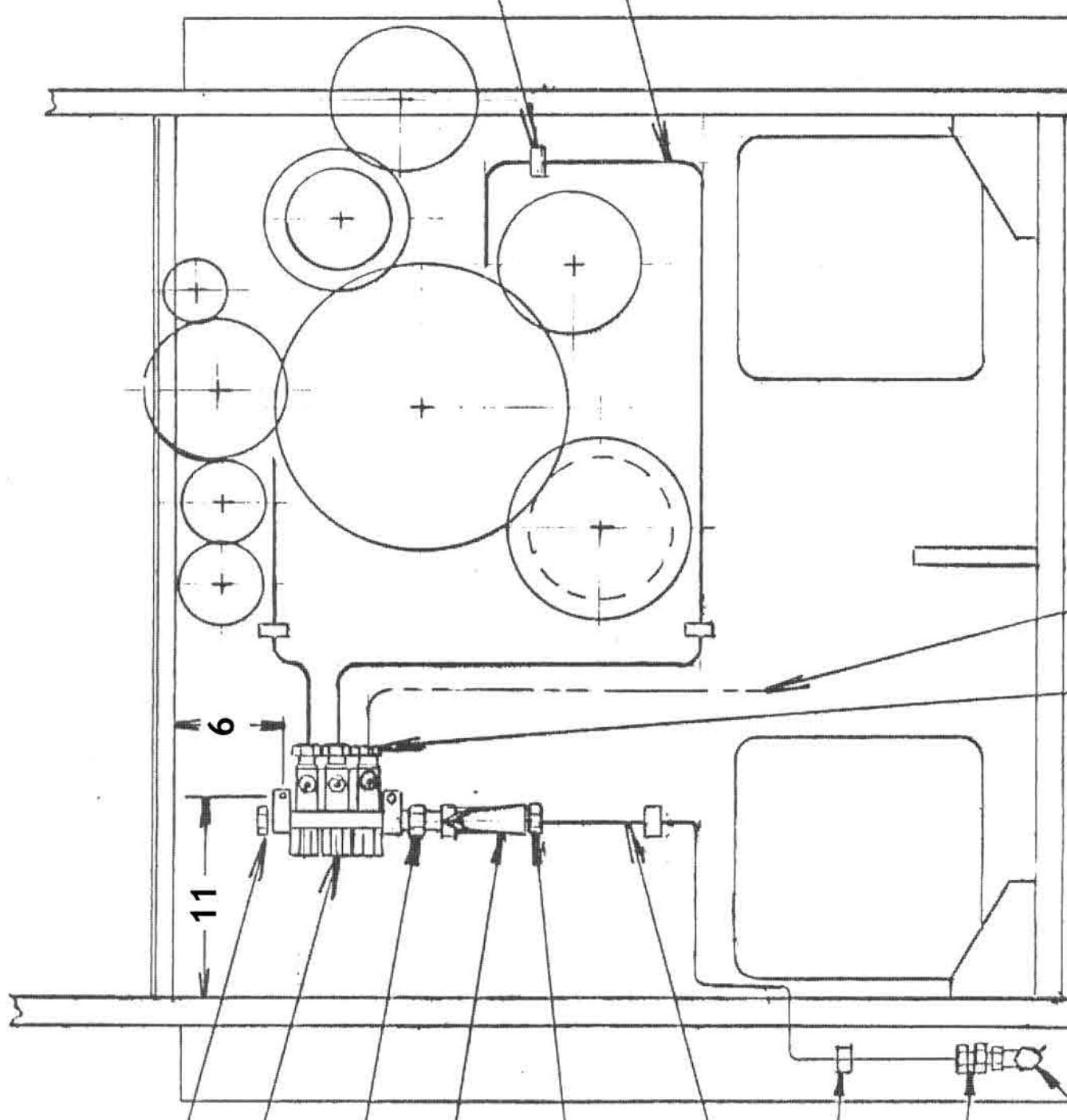
- * Location and/or quantity not indicated on drawing and/or parts list
- ~ Indicates interchangeable parts (Lincoln / Parker)

DATE	SYM	REVISION RECORD	DR.	CK.

Note 1

Note 2

ITEM NO.	LINCOLN PARTS	PARKER PARTS	DESCRIPTION
1	053032	053054	MALE CONNECTOR 3/8 T X 1/4 NPT
2	053034		FEMALE ELBOW 5/8 T X 1/4 NPT
2	053032	053058	FEMALE ELBOW 5/8 T X 1/2 NPT
3	053032		MALE CONNECTOR 3/8 T X 1/2 NPT
3		053056	MALE CONNECTOR 3/8 T X 1/4 NPT



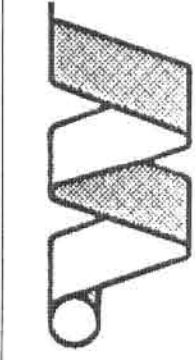
TO OPERATOR SIDE FRAME
X-PERF ONLY (OPTIONAL)

(WHEN X-PERF LINE NOT INSTALLED)

Note 1
LINCOLN PARTS ONLY
WHERE INDICATED

Note 2
SUBSTITUTE PARKER PARTS
WHERE INDICATED

TOLERANCES (EXCEPT AS NOTED)	
DECIMAL	.01
.XX	.005
XXX	.005
FRACTIONAL	
±	1/32
ANGULAR	
±	1 Deg



WEB PRESS LLC
701 EAST D ST., TACOMA, WA 98002

TITLE

ATLAS FOLDER AUTOLUBE

DRAWN BY W E N.

DWG NO. 1833000

APPROVED BY XXXXX

DATE 9-30-95

SCALE XXXXX

SIZE B

REV -

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ATLAS FOLDER
AUTO LUBRICATION SYSTEM ACCESSORIES 1834000

PART NO.	DESCRIPTION	QTY. REQ'D
051010*/***	ELBOW, 360° SWIVEL, BRASS ¼”NPT X ¼”T	2
051053*	CONNECTOR, STRAIGHT MALE , PNEUMATIC, 3/8NPT X ½”T	1
051058**	CONTROL, PNEUMATIC AIR LINE	1
051063	NIPPLE, PNEUMATIC HEX, S.S. ¼”NPT X ¼”NPT	1
052035	REDUCER, PIPE THREAD, HYDRAULIC, ½”NPT X ¼”NPT “F”	1
053023	DISPENSER, GREASE (BUCKET PUMP WITH HOSE)	1
053035	TUBE, HYDRAULIC, 5/8”OD X.049 WALL SEAMLESS STEEL	A/R FT
053037	PUMP, CENTROMATIC 25:1	1
053038	ALARM KIT, LOW LEVEL	1
053042	ELBOW, MALE, 5/8”T X ½” NPT	1
053044	GREASE, LUBRICATION (5 GAL., LUBRIPLATE 15006)	1
053046	TEE, UNION, 5/8” T	1
053047	“L”, UNION, 5/8”T	3
053068*	FERRULE, 1/8”	6
053069*	FERRULE, 3/8”	6
053070*	FERRULE, 5/8”	6
053114*	SOLENOID, 24 VDC	

* Location and/or quantity not indicated on drawing and/or parts list

** Note: One Required Per Press Line

*** Note: Required With Air Line Control

ATLAS FOLDER
OPTION: AUTO LUBE SYSTEM 1834000A1

PART NO.	DESCRIPTION	QTY. REQ'D
053029*	ELBOW, MALE, 3/8" T X 1/4" NPT	1
053032	CONNECTOR, MALE 3/8" T X 1/4" NPT	1
053026	CLAMP, TUBE, 3/8" OD	2
053017^^^^	TUBE, 3/8" OD, STEEL	A/R

OPTION: AUTO LUBE 1834000A2

053075^	UNION, 5/8" T X 5/8" T	A/R
053031^	BRANCH, FEMALE "T" 5/8" T X 1/4" NPT	A/R
052035^^	REDUCER, PIPE THREAD "M" 1/2" NPT X 1/4" NPT "F"	A/R

OPTION: AUTO LUBE 1834000A3

052035^^	REDUCER, PIPE THREAD "M" 1/2" NPT X 1/4" NPT "F"	A/R
053034^^^	ELBOW, FEMALE 5/8 T X 1/4" NPT	A/R

OPTION: AUTO LUBE T & A 1834000A4

052035	REDUCER, PIPE THREAD "M" 1/2" NPT X 1/4" NPT "F"	A/R
053047	UNION "L" 5/8" T	4

OPTION: AUTO LUBE CROSS PERFORATOR 1834000A5

053018	TUBE, 1/8" OD, STEEL	4 FT
053024	CLAMP, TUBE, 1/8" OD	4

OPTION: AUTO LUBE UPPER FORMER 1834000A6

051117*	TEE, FEMALE 1/4" NPT	1
051012*	NIPPLE, MALE HEX, BRASS, 1/4" NPT X 1/4" NPT	1
053032*	CONNECTOR, MALE, 3/8" T X 1/4" NPT	1
053022*	UNION, 3/8" TUBE X 3/8" TUBE	1
053017*	TUBE3, 3/8" OD, STEEL	12 FT

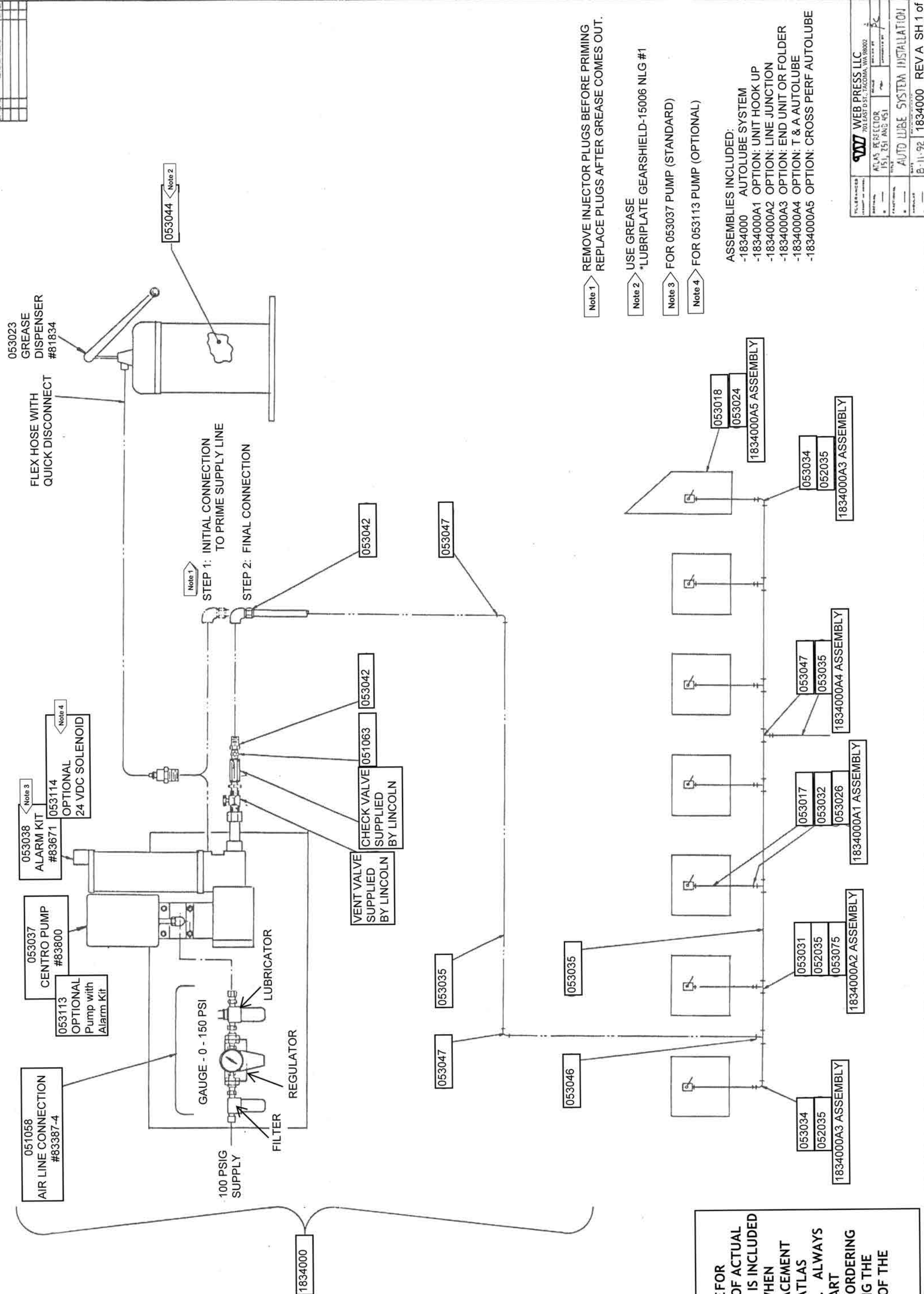
^ Quantity 1 each per Unit/4-Color/Folder (except end unit)

^^ Required if Parker fitting used.

^^^ For Units next to Roll Stand and End Units only

^^^^ Quantity 3 Feet=Unit; 3 Feet=4-Color; 6 Feet=Folder

* Location and/or quantity not indicated on drawing and/or parts list



Note 1 REMOVE INJECTOR PLUGS BEFORE PRIMING
REPLACE PLUGS AFTER GREASE COMES OUT.

Note 2 USE GREASE
*LUBRIPLATE GEARSHIELD-15006 NLG #1

Note 3 FOR 053037 PUMP (STANDARD)

Note 4 FOR 053113 PUMP (OPTIONAL)

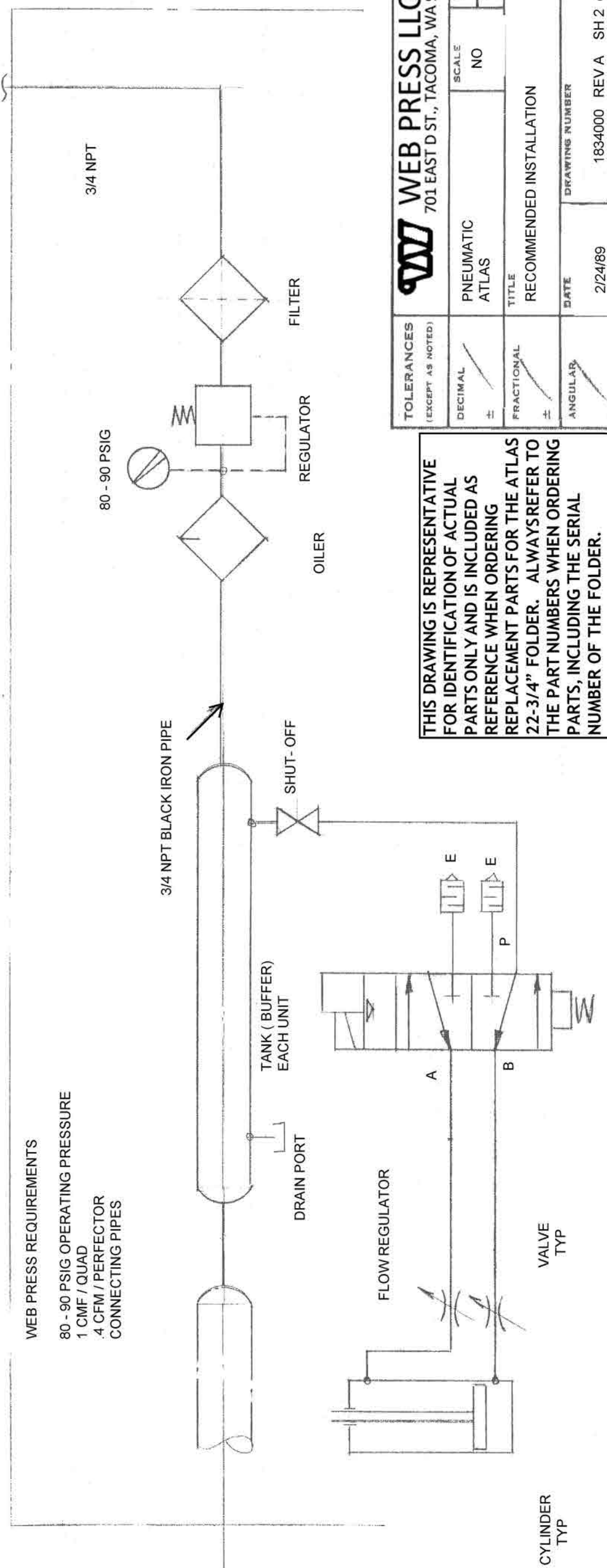
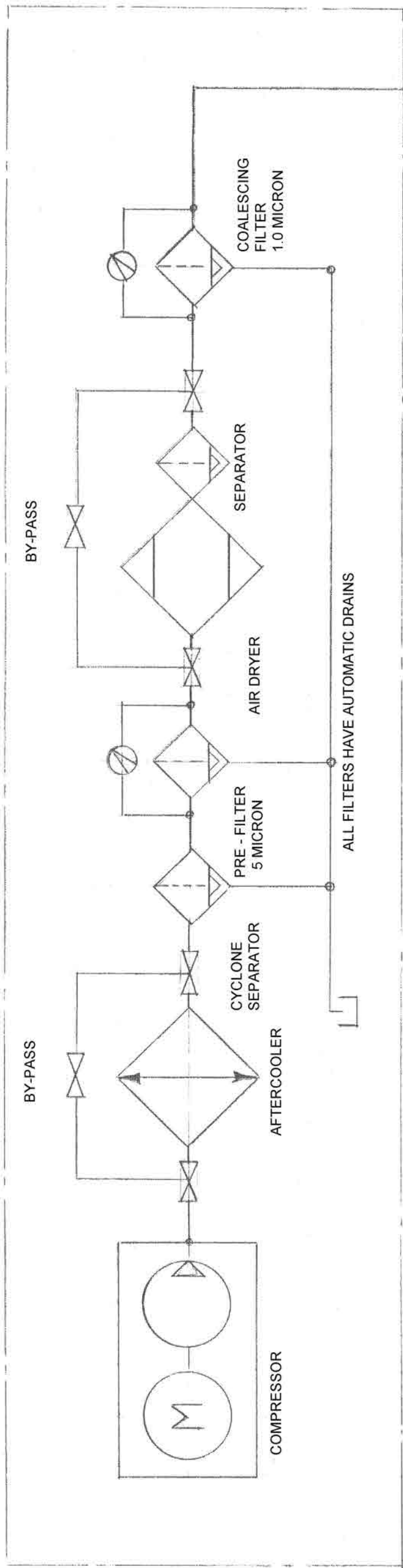
- ASSEMBLIES INCLUDED:
- 1834000 AUTOLUBE SYSTEM
 - 1834000A1 OPTION: UNIT HOOK UP
 - 1834000A2 OPTION: LINE JUNCTION
 - 1834000A3 OPTION: END UNIT OR FOLDER
 - 1834000A4 OPTION: T & A AUTOLUBE
 - 1834000A5 OPTION: CROSS PERF AUTOLUBE

THIS DRAWING IS REPRESENTATIVE FOR IDENTIFICATION OF ACTUAL PARTS ONLY AND IS INCLUDED AS REFERENCE WHEN ORDERING REPLACEMENT PARTS FOR THE ATLAS 22-3/4" FOLDER. ALWAYS REFER TO THE PART NUMBERS WHEN ORDERING PARTS, INCLUDING THE SERIAL NUMBER OF THE FOLDER.

WEB PRESS LLC 701 EAST D ST., TACOMA, WA 98002	
ATLAS PERCEPTOR 151, 251 AND 451	DATE: 8-11-92
AUTO LUBE SYSTEM INSTALLATION	REV A SH 1 of 2

DATE/SYM	REVISION RECORD	DR. CK.

TYPICAL AIR COMPRESSOR INSTALLATION



THIS DRAWING IS REPRESENTATIVE FOR IDENTIFICATION OF ACTUAL PARTS ONLY AND IS INCLUDED AS REFERENCE WHEN ORDERING REPLACEMENT PARTS FOR THE ATLAS 22-3/4" FOLDER. ALWAYS REFER TO THE PART NUMBERS WHEN ORDERING PARTS, INCLUDING THE SERIAL NUMBER OF THE FOLDER.

TOLERANCES (EXCEPT AS NOTED)	DECIMAL	±	FRACTIONAL	±	ANGULAR	±
WEB PRESS LLC 701 EAST D ST., TACOMA, WA 98002	PNEUMATIC ATLAS	SCALE	NO	DRAWN BY	APPROVED BY	
	TITLE	RECOMMENDED INSTALLATION		DATE	DRAWING NUMBER	
				2/24/89	1834000	REVA SH 2 of 2



Delivery Table Assembly

ATLAS FOLDER
6' DELIVERY TABLE 618003

PART NO.	DESCRIPTION	QTY. REQ'D
001001	BEARING, ER-16	4
031004	ROLL PIN, ¼" DIAMETER X 1" LONG	A/R
040410	MOTOR, ¼ HP 180 RPM, 909 VOLT 3XA84	1
063005	CHAIN, CONNECTING LINK, #41 2P	1
063008	CHAIN, #41, 1/3 P (LINKS)	26
090046	TAPE, DEXON, 1-1/2" W X 142" LONG	4
618082	PLATE, ADJUST DELIVERY TABLE	1
618090	SHAFT ROLLER	2
618110	TUBE DELIVERY TABLE	1
618131	SPACER	4
618141	FINGERS, DELIVERY CATCHER	3
618180	DELIVERY TABLE	1
618240	SPROCKET, DRIVEN	1
618251	SPROCKET, DELIVERY TABLE	1
618260	TUBE ASSEMBLY	1
618270	GUARD	1

OPTION: ATLAS DELIVERY TABLE 618002A1

618042	LEG, DELIVERY TABLE	2
618281	LEG, DELIVERY TABLE	2
618480	TABLE LEG	4

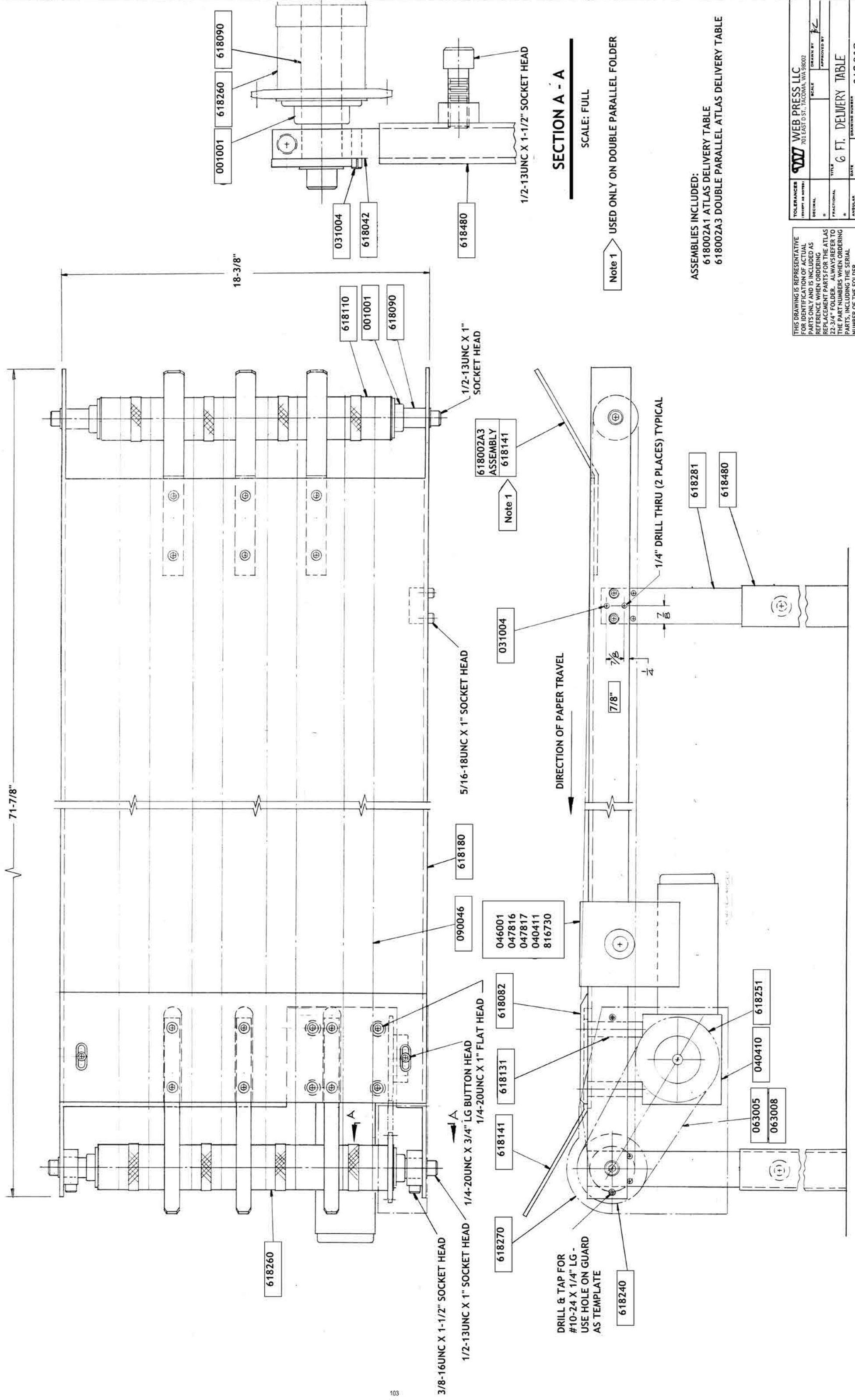
OPTION: DOUBLE PARALLEL ATLAS DELIVERY TABLE 618002A3

618141	FINGERS, DELIVERY CATCHER	3
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OPTION: MOTOR CONTROL 040410

040411	SPEED CONTROLLER 2M510	1
046001	POWER CORD 1W950	1
046018	CONNECTOR, ½" FLEX (90)	2
046089	GROUND LUG	1
047816	ELECTRICAL BACKPANEL, 6 X 4	1
047817	ELECTRICAL ENCLOSURE, 6 X 4 X 4	1
048102	CONNECTOR, ½" CORD	1
618730	MOUNTING PLATE, MOTOR CONTROL	1

DATE	SYM	DESCRIPTION	BY	CHK.
11-22-04	A	NEW RELEASE CN# 1483	BC	



SECTION A - A

SCALE: FULL

Note 1 USED ONLY ON DOUBLE PARALLEL FOLDER

ASSEMBLIES INCLUDED:
 618002A1 ATLAS DELIVERY TABLE
 618002A3 DOUBLE PARALLEL ATLAS DELIVERY TABLE

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TOLERANCES	UNLESS NOTED	ORIGINAL	SCALE	DRAWN BY	APPROVED BY
<p>WEB PRESS LLC 701 EAST D ST., TACOMA, WA 98602</p>					
<p>TITLE: 6 FT. DELIVERY TABLE</p>					
<p>DATE: 11-22-04 DRAWING NUMBER: 618003</p>					

ATLAS FOLDER

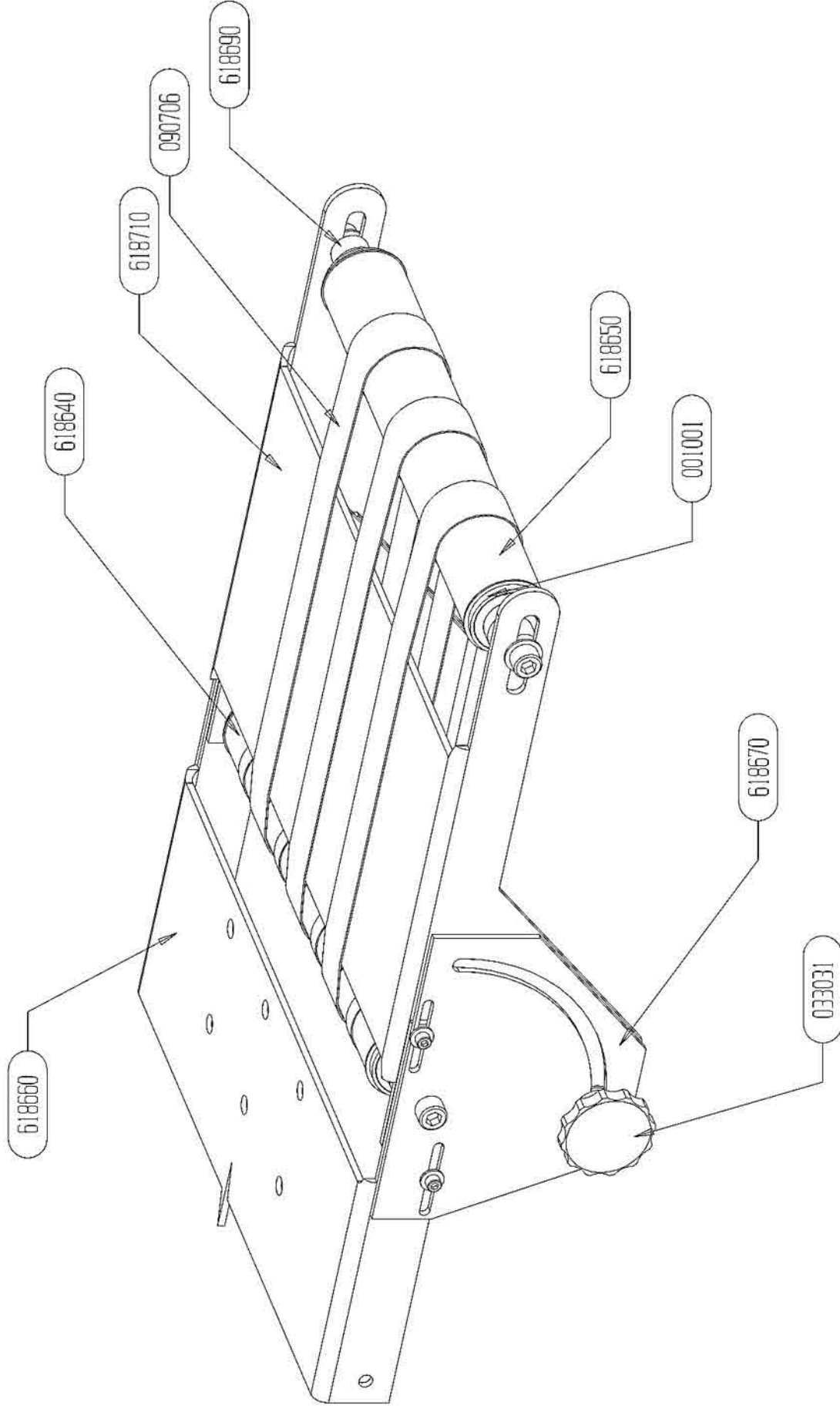
OPTION: EXTENSION DOUBLE PARALLEL DELIVERY TABLE 618720

PART NO.	DESCRIPTION	QTY. REQ'D
001001	BEARING, ER-16	2
033031	KNOB, CLAMPING, WITH 3/8-16 X 1" STUD	2
090706	TAPE	3
618640*	TUBE, DELIVERY ROLLER	1
618650	TUBE, DELIVERY TABLE	1
618660**	DELIVERY TABLE	1
618670	PLATE ADJUSTMENT	2
618690	STIFFENER SHAFT	1
618710	EXTENSION TABLE	1

*Note: Replaces 618110 on Parts List 618002

**Note: Replaces 618180 on Parts List 618002

DATE	SYM	REVISION RECORD	DR.	CK.

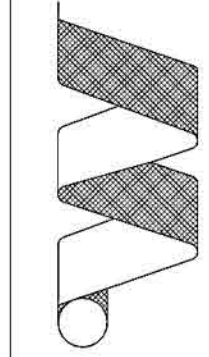


- NOTES:
1. REWORK ITEM 618180 TO MAKE ITEM 618660 BY DRILLING AND TAPPING (4) HOLES
 2. REMOVE ITEM 618141
 3. REPLACE ITEM 618110 WITH ITEM 618640

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TOLERANCES (EXCEPT AS NOTED)	
DECIMAL	± .01
.XX	± .005
.XXX	± .005
FRACTIONAL	± 1/32
ANGULAR	± 1 Deg

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DRAWN BY G. VARGAS

APPROVED BY X

WEB PRESS LLC
 701 EAST D ST., TACOMA, WA 98002

TITLE
**EXTENSION,
 DELIVERY TABLE**

X
 DWG NO. **618720**

SCALE 1/4 DATE 3-24-04 SIZE B

REV - A



Kicker Assemblies

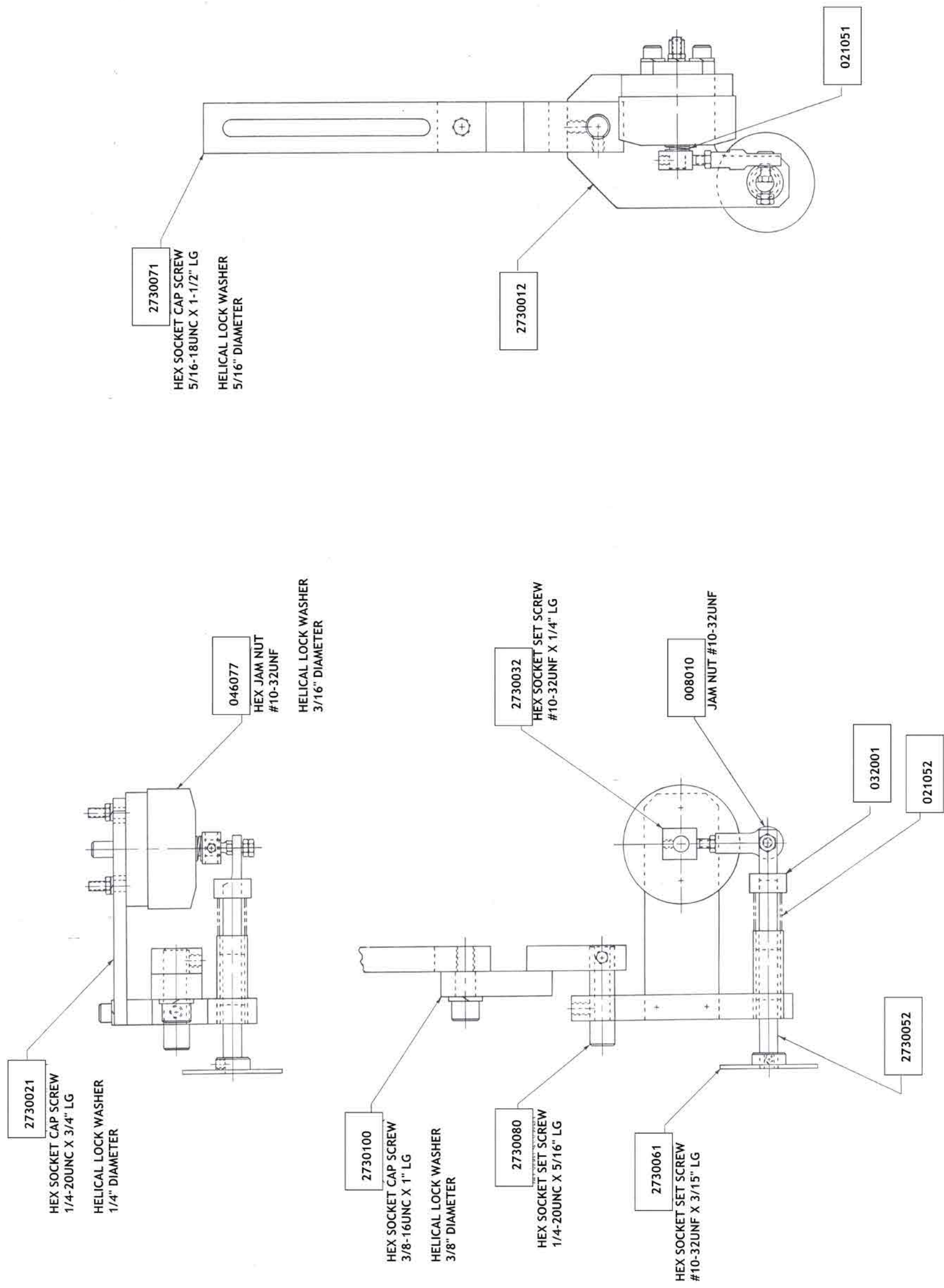
ATLAS FOLDER
KICKER ASSEMBLY QUARTER FOLD / HALF FOLD 2730001

PART NO.	DESCRIPTION	QTY. REQ'D
008010	ROD END, FEMALE, WITH STUD	2
021051	SPRING, COMPRESSION	2
021052	SPRING, COMPRESSION	2
032001	SET COLLAR, 3/8" X 3/4" OD	2
046077	SOLENOID, ROTARY, S8 204-0272A	2
2730012	PLATE, MOUNTING	2
2730021	PLATE, SOLENOID MOUNTING	2
2730032	LEVER, ACTUATOR	2
2730052	SHAFT, ACTUATOR	2
2730061	PUSHER	2
2730071	KICKER, MOUNTING PLATE	2
2730080	SHAFT, MOUNTING	2
2730100	KICKER, MOUNTING BRACKET	2

OPTION: KICKER ASSEMBLY DOUBLE PARALLEL 2nd JAW 2730001A

008010	ROD END, FEMALE WITH STUD	1
021051	SPRING, COMPRESSION	1
021052	SPRING, COMPRESSION	1
032001	SET COLLAR, 3/8" X 3/4" OD	1
046077	SOLENOID, ROTARY, S8 204-0272A	1
2730012	PLATE, MOUNTING	1
2730021	PLATE, SOLENOID MOUNTING	1
2730032	LEVER, ACTUATOR	1
2730052	SHAFT, ACTUATOR	1
2730061	PUSHER	1
2730071	KICKER MOUNTING PLATE	1
2730100	BRACKET, KICKER MOUNTING	1
2730130	SHAFT, MOUNTING	1

THIS DRAWING IS REPRESENTATIVE FOR IDENTIFICATION OF ACTUAL PARTS ONLY AND IS INCLUDED AS REFERENCE WHEN ORDERING PARTS FOR THE ATLAS 22.34" FOLDER. ALWAYS REFER TO THE PART NUMBERS AND/OR DRAWING PART NUMBERS INCLUDING THE SERIAL NUMBER OF THE FOLDER.





T&A Assemblies

ATLAS FOLDER
LOWER T & A ASSEMBLY-LINE 1 2727000A

PART NO.	DESCRIPTION	QTY. REQ'D
001054	BEARING, ER-16X	2
033020	HANDLE, 2-4/4 X 3/8-16	2
069001	RINGFEEDER, 38 X 44	2
611310	WHEEL, TROLLEY	2
727040	CLAMP DISC	1
1611092	STUB SHAFT, TROLLEY WHEEL	2
1611310	NUT, BARREL	2
1611322	TRUNION, ADJUST	2
1611330	ROD, ADJUSTMENT	2
1611341	PLUG, TIE-IN	2
1611351	PLUG, TIE-IN	2
1613271*	SPACER, PINCH ROLL	3
1613280**	SPACER, PINCH ROLL	2
2723110	Nip Roll, Half-Fold Cross Perforator	1
2727190	STIFFENER, SHAFT, TROLLEY	1
2727210	ARM, TROLLEY WHEEL	4
2727222	BAR, TROLLEY ADJUST	2

*Note: Replaces (2 each) 1613080 on Standard Folder

**Note: Replaces (2 each) 1613090 on Standard Folder

OPTION: T & A ASSEMBLY –
LINE ONE WITHOUT PERFORATOR – 22-3/4 2727000A1

001014	BEARING, ER-36	2
2727200	FORWARDING DRUM	1
2727340	GEAR, T & A DRUM DRIVE	1

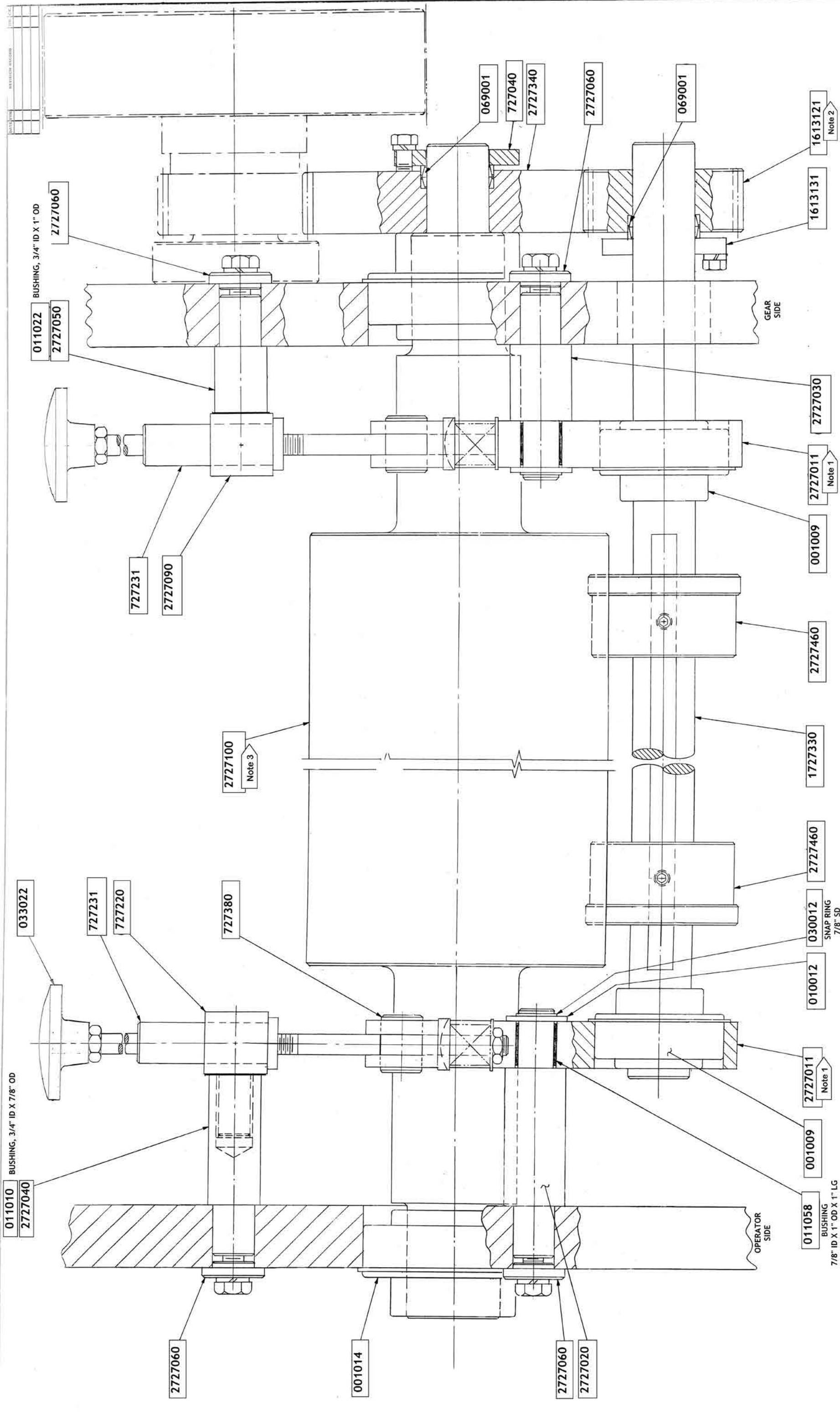
ATLAS FOLDER
OPTION: T & A ASSEMBLY –
LINE TWO – WITHOUT PERFORATOR – 22-3/4 2727000A2

PART NO.	DESCRIPTION	QTY. REQ'D
001014	BEARING, ER-36	2
2727100	FORWARDING DRUM	1
2727340	GEAR, T & A DRUM DRIVE	1
LOWER T & A ASSEMBLY-LINE 2 2727000B		
001009	BEARING, ER-24	2
001054	BEARING, ER-16X	2
005012	WASHERS, SPHERICAL, ½"ID	2
005018	BEARING, THRUST, ¼" X 5/8" X 1/16 THK	2
010012	BUSHING, BRONZE, 7/8"ID X 1-1/2"OD X 1/8" THK	2
021023	SPRING, BLUE, 1"OD X 3" LG	2
024002	WASHER, 1" X ½" X .35 THK	1
032010	SET COLLAR (2 PIECE)	2
032012	SET COLLAR, 1"ID X 1-3/4" (2 PIECE)	2
033022	HANDLE, 2-3/4"OD X ½-13	3
035016	SCREW, SHOULDER, ½" X ½" LG	1
069001	RINGFEEDER, 38 X 44	4
727040	CLAMP DISC	1
727191	SCREW, ADJUSTING	2
727220	TRUNNION, ADJUSTING	1
727231	NUT, ADJUSTING	2
727380	TRUNNION ARM	2
727630	ROD, ADJUSTING T & A	1
1613131	CAP, NIP ROLL GEAR	1
1727330	SHAFT, NIP ROLL	1
1727400	ROLLER, STEERING	1
2727020	ROD, PIVOT, OPERATOR SIDE	1
2727030	ROD, PIVOT, GEAR SIDE	1
2727040	TRUNNION, ADJUSTING, OPERATOR SIDE	1
2727050	TRUNNION, ADJUSTING	1
2727060	CAP	4
2727071	SHAFT, STEERING ROLL	1

ATLAS FOLDER
OPTION: T & A ASSEMBLY –
LOWER T & A ASSEMBLY-LINE 2 2727000B (continued)

PART NO.	DESCRIPTION	QTY. REQ'D
2727090	TRUNNION, GEAR SIDE	1
2727150	ROD, ADJUSTING NIP ROLL	2
2727161	ROD, ADJUSTING STEERING ROLL	1
2727170	GUIDE, ADJUSTING ROD, OPERATOR SIDE	1
2727180	GUIDE, ADJUSTING ROD, GEAR SIDE	1
2727310	BLOCK, STEERING ROLL ADJUSTMENT	1
2727320	PLATE, STEERING ROLL	2
2727330	BLOCK, STEERING ROLL	1
2727370	HANDLE, STEERING ROLL ADJUSTMENT	1
2727460	NIP ROLL, ATLAS T & A	2

Note: For blade requirement, reference Assembly 2723000A1, 2723000A2, 2723000A3



011010 BUSHING, 3/4" ID X 7/8" OD
2727040

011022 BUSHING, 3/4" ID X 1" OD
2727050

011058 BUSHING
7/8" ID X 1" OD X 1" LG

011058 BUSHING
7/8" ID X 1" OD X 1" LG

030012 SNAP RING
7/8" SD

2727030

1613131

1613121

Note 2

Note 1

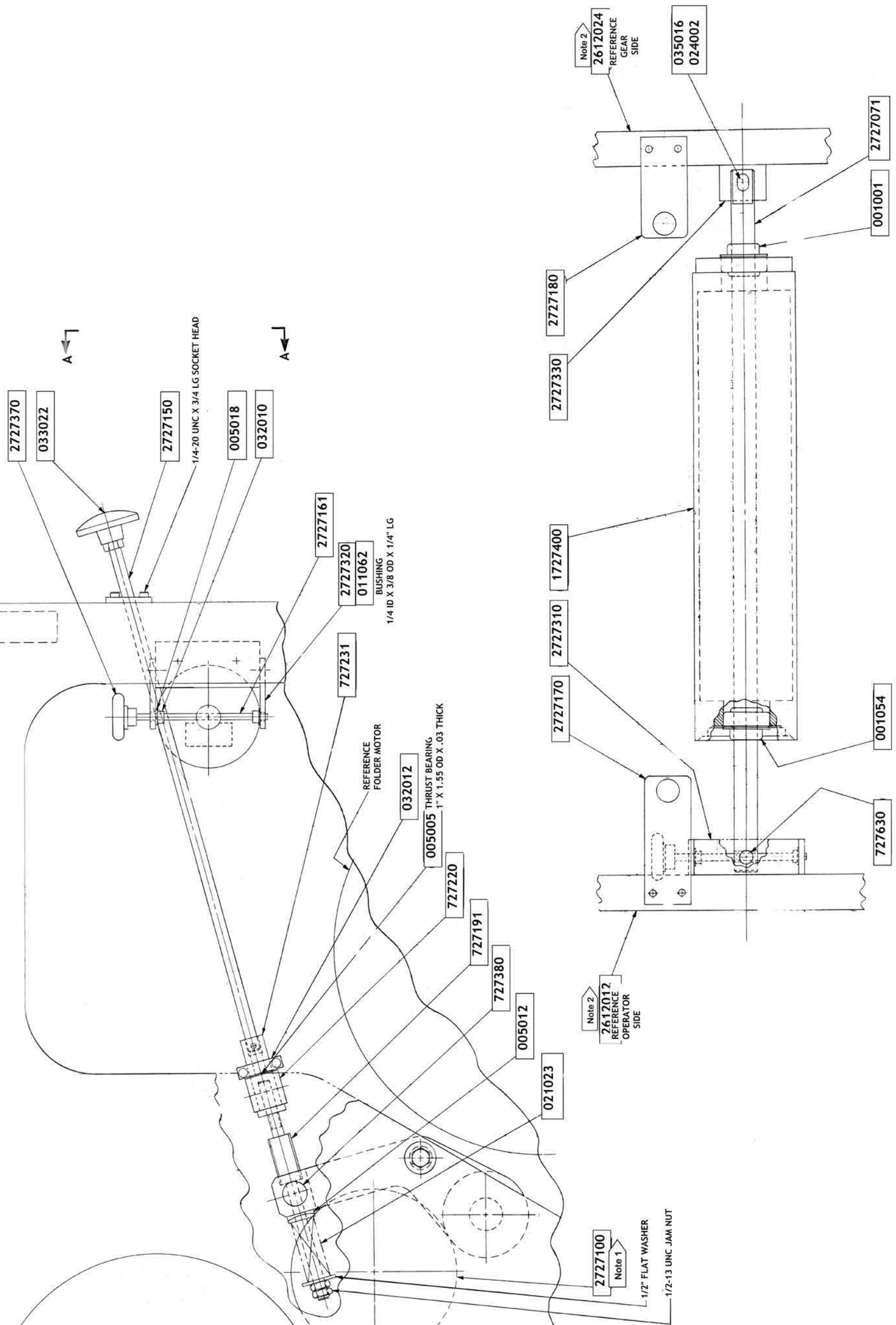
2727100
Note 3

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NOTES:
1. SEE ASSEMBLY 2727000BA1
2. SEE ASSEMBLY 1619001A
3. SEE ASSEMBLY 2727000A2

TOLERANCES UNLESS OTHERWISE SPECIFIED		WEB PRESS LLC 701 EAST D ST., TACOMA, WA 98002	
ORIGINAL	BASIC T & A	SCALE	DRAWN BY
ASSEMBLY	W/O PERM.	FULL	APPROVED BY
LOWER T & A ASSEMBLY LINE I		DRAWING NUMBER	
6-7-90 SH1 1 of 2		2727000A2 B	

DATE	DESCRIPTION	BY	CHKD



VIEW A-A

NOTES:
1. SEE ASSEMBLY 2727000A2
2. SEE ASSEMBLY 2612001

ASSEMBLIES SHOWN:
2727000A AND 2727000A1
LOWER T & A - LINE 1

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TOLERANCES UNLESS NOTED:	WEB PRESS LLC 701 EAST D ST., TACOMA, WA 98002
ORIGINAL	DRAWN BY: JEM
FRACTIONAL	SCALE: HALF
ANGULAR	APPROVED BY:
	TITLE: LOWER T & A. ASSEMBLY LINE II
	DATE: 6-11-90
	DRAWING NUMBER: 2727000A2 & B

ATLAS FOLDER
OPTION: T & A ASSEMBLY –
LINE ONE WITH PERFORATOR – 22-3/4 2727000B1

PART NO.	DESCRIPTION	QTY. REQ'D
001014	BEARING, ER-36	4
090341	CHEEKWOOD, URETHANE, NO BEVEL	4
614111	BAR, CUTTING KNIFE	1
614121	BAR, CUTTING KNIFE	1
2614050	COUNTERWEIGHT	1
2616271	GEAR, RH BACKLASH	1
2723050	HUB, PERFORATOR GEAR	1
2723061	GEAR, PERFORATOR SHAFT	1
2723070	WASHER	1
2723170	HUB, GEAR	1
2727301	GEAR, PERFORATOR ANVIL	1

Note: For blade requirement, reference Assembly 2723000A1, 2723000A2, 2723000A3

OPTION: T & A ASSEMBLY –
LINE ONE –STANDARD FOLDER – 22-3/4 2727000B1A

2734051	CYLINDER, PERFORATOR	1
2734091	ANVIL, PERFORATOR	1

OPTION: T & A ASSEMBLY –
LINE ONE – DOUBLE PARALLEL FOLDER– 22-3/4 2727000B1B

090341	CHEEKWOOD, URETHANE, NO BEVEL	8
614111	BAR, CUTTING KNIFE	2
614121	BAR, CUTTING KNIFE	2
2723150	CYLINDER, PERFORATOR ANVIL	1
2734120	KNIFE CYLINDER, PERFORATOR	1

ATLAS FOLDER
OPTION: T & A ASSEMBLY –
LINE TWO – WITH PERFORATOR- 22-3/4 OLD GEAR 2727000B2

PART NO.	DESCRIPTION	QTY. REQ'D
001014	BEARING, ER-36	4
614111	BAR, CUTTING KNIFE	1
614121	BAR, CUTTING KNIFE	1
090341	CHEEKWOOD, URETHANE, NO BEVEL	4
1613280*	SPACER, PINCH ROLL	2
1613271**	SPACER, PINCH ROLL	3
2723050	Hub, Perforator Gear	1
2723061	GEAR, PERFORATOR SHAFT	1
2723110***	NIP ROLL, HALF FOLD CROSS PERFORATOR	1
2723070	WASHER	2
2727340	GEAR, T & A DRIVE DRIVE	1
2727301	GEAR, PERFORATOR ANVIL	1
2614050	COUNTERWEIGHT	1

*Note: Replaces (2) 1613090 on Standard Folder

**Note: Replaces (2) 1613080 on Standard Folder

***Note: Replaces (1) 1613141 on Standard Folder

OPTION: T & A ASSEMBLY –
LINE TWO – STANDARD FOLDER 2727000B2A

2734051	CYLINDER, PERFORATOR	1
2724031	ANVIL, PERFORATOR	1

OPTION: T & A ASSEMBLY –
LINE TWO – DOUBLE PARALLEL FOLDER 2727000B2B

2723160	ANVIL, PERFORATOR	1
2734120	KNIFE CYLINDER, PERFORATOR	1
614111	BAR, CUTTING KNIFE	2
614121	BAR, CUTTING KNIFE	2
090341	CHEEKWOOD, URETHANE, NO BEVEL	8

ATLAS FOLDER
OPTION: T & A ASSEMBLY –
LINE TWO – FOR OLD FRAMES 2727000BA1

PART NO.	DESCRIPTION	QTY. REQ'D
2727011	ARM, PIVOT	2

OPTION: T & A ASSEMBLY –
LINE TWO – FOR NEW FRAMES 2727000BA2

2727013	ARM, PIVOT	2
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OPTION: T & A ASSEMBLY –
LINE TWO – WITH PERFORATOR – 22-3/4 – NEW GEAR 2727001B2

001014	BEARING, ER-36	4
614111	BAR, CUTTING KNIFE	1
614121	BAR, CUTTING KNIFE	1
090341	CHEEKWOOD, URETHANE, NO BEVEL	4
1613280*	SPACER, PINCH ROLL	2
1613271**	SPACER, PINCH ROLL	3
2723050	HUB, PERFORATOR, GEAR	1
2723061	GEAR, PERFORATOR SHAFT	1
2723110***	NIP ROLL, HALF-FOLD CROSS PERFORATOR	1
2723070	WASHER	2
2617271	GEAR, T & A DRUM DRIVE	1
2723170	HUB, GEAR	1
2727301	GEAR, PERFORATOR ANVIL	1
2614050	COUNTERWEIGHT	1

*Note: Replaces (2) 1613090 on Standard Folder

**Note: Replaces (2) 1613080 on Standard Folder

***Note: Replaces (1) 1613141 on Standard Folder



Perforator Assemblies

ATLAS FOLDER
22-3/4 ATLAS CROSS PERFORATOR ASSEMBLY 2723001

Reference Drawing 2611001 & 2612001

PART NO.	DESCRIPTION	QTY. REQ'D
001014	BEARING, ER-36	4
001054	BEARING, ER-16	2
033020	HANDLE, 2-3/4" X 3/8-16 HANDLE	2
090341	CHEEKWOOD, UREATHANE, NO BEVEL	4
611310	WHEEL, TROLLEY	2
614111	BAR, CUTTING KNIFE	1
614121	BAR, CUTTINGKNIFE	1
1611092	STUB SHAFT, TROLLEY WHEEL	2
1611310	NUT, BARREL	2
1611322	TRUNION, ADJUST	2
1611330	ROD, ADJUST	2
1611341	PLUG, TIE-IN	2
1611351	PLUG, TIE-IN	2
1613271**	SPACER, PINCH ROLL	3
1613280***	SPACER, PINCH ROLL	2
2614050	COUNTER WEIGHT	1
2616271	GEAR, RIGHT HAND BACKLASH	1
2723050	HUB, PERFORATOR GEAR	1
2723061	GEAR, PERFORATOR SHAFT	1
2723070	WASHER	2
2723110*	NIP ROLL, HALF-FOLD CROSS PERFORATOR	1
2723170	HUB, GEAR	1
2727190	STIFFENER, SHAFT, TROLLEY	1
2727210	ARM, TROLLEY WHEEL	4
2727222	BAR, TROLLEY ADJUST	2
2727301	GEAR, PERFORATOR ANVIL	1

*Note: Replaces (1 each) 1613141 on Standard Folder

**Note: Replaces (2 each) 1613080 on Standard Folder

***Note: Replaces (2 each) 1613090 on Standard Folder

ATLAS FOLDER
OPTION: BLADE PERFORATOR, STANDARD PRINT 2723000A1
Reference Drawing 2611001 & 2612001

PART NO.	DESCRIPTION	QTY. REQ'D
090323	KNIFE, 20" SERRATED PERFORATOR, LIGHT STOCK 10 TPI	1

OPTION: BLADE PERFORATOR, 30 / 40 BOOKSTOCK 2723000A2

Reference Drawing 2611001 & 2612001

090324	KNIFE, 20" SERRATED PERFORATOR, HEAVY STOCK 16 TPI	1
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OPTION: BLADE PERFORATOR, 50 / 60 BOOKSTOCK 2723000A3

Reference Drawing 2611001 & 2612001

090220	BLADE, 50 / 60 BOOKSTOCK PERFORATOR HALF-FOLD	1
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OPTION: STANDARD FOLDER CROSS PERFORATOR 2723000B1

2734051	PERFORATOR CYLINDER	1
2734091	PERFORATOR ANVIL	1

**OPTION: DOUBLE PARALLEL FOLDER CROSS PERFORATOR
2723000B2**

090341	CHEEKWOOD, URETHANE, NO BEVEL	8
614111	BAR, CUTTING KNIFE	2
614121	BAR, CUTTING KNIFE	2
2723150	ANVIL CYLINDER PERFORATOR	1
2734120	KNIFE CYLINDER PERFORATOR	1

**ATLAS FOLDER
LINEAR (NIPS) PERFORATOR 1724000A1**

PART NO.	DESCRIPTION	QTY. REQ'D
1724020	COLLAR, PERFORATOR WHEEL	1
1724030	ANVIL, PERFORATOR WHEEL	1
1724040	CLAMP	1
OPTION: PERFORATOR WHEEL STANDARD PRINT 1724000A2		
1724010	PERFORATOR WHEEL	1
OPTION: PERFORATOR WHEEL BOOKSTOCK PRINT 30 / 40 LB 1724000A3		
1724050	PERFORATOR WHEEL, BOOKSTOCK	1
OPTION: PERFORATOR WHEEL BOOKSTOCK PRINT, 50 / 60 LB 1724000A4		
1724010	PERFORATOR WHEEL, BOOKSTOCK	1
OPTION: ROLLER TO FOLD LINEAR PERFORATOR, STANDARD 1724000B1		
090040	PERFORATOR WHEEL	1
OPTION: ROLLER TO FOLD PERFORATOR, BOOKSTOCK 30 / 40 LB 1724000B2		
090217	PERFORATOR WHEELS, RTF 1Q, PERFORATOR	1
OPTION: ROLLER TO FOLD PERFORATOR, BOOKSTOCK 50 / 60 LB 1724000B3		
090213	PERFORATOR WHEELS, 2 PER INCH	1



Angle Bars

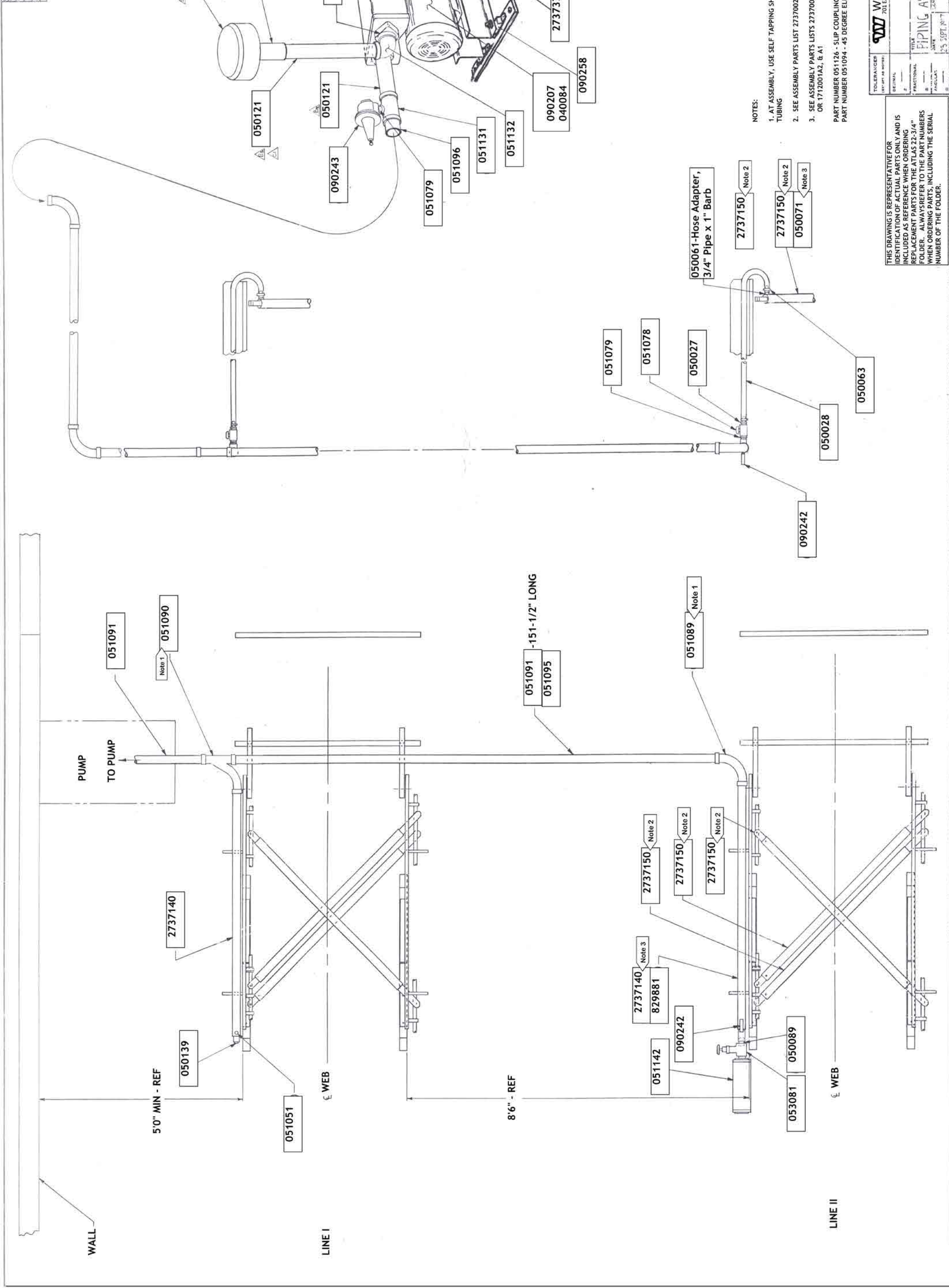
ATLAS FOLDER
OPTION: AIR LOADED ANGLE BARS 2737002

PART NO.	DESCRIPTION	QTY. REQ'D
032013	SET COLLAR, 2-PIECE, 3/4 " X 1-1/2"	4
050021	COUPLER, 1" SLIP X 1" THREADED	1
050022	ELBOW, 90°, 1" SKT X 1" PVCBS2E	5
050077	ELBOW, 3/4" NPT X 1" BARB	3
051092	PIPE PLUG, 3/4" MNPT SOCKET DRIVE	3
733141	ANGLE BAR, SLIDE , GEAR SIDE TOP	3
733160	BLOCK, ANGLE BAR ADJUSTMENT	3
733170	NUT, BACKLASH	6
733191	SCREW, ANGLE BAR ADJUSTING	3
733230	BLOCK, SLIDE SCREW, GEAR SIDE	6
733240	BLOCK SCREW, ADJUST	3
733540	KNOB	3
2727060	CAP	10
2737103	COMPENSATOR ASSEMBLY	1
2737150	ANGLE BAR, AIR LOADED	3
2737300	ANGLE BAR SIDE FRAME, GEAR SIDE	1
2737310	ANGLE BAR SIDE FRAME, OPERATOR SIDE	1
2737340	PLATE, IDLER GEAR SIDE	2
2737350	PLATE, IDLER GEAR, OPERATOR SIDE	2
2738160	SHAFT, STIFFENER	5

ATLAS FOLDER
OPTION: ANGLE BAR PIPING ASSEMBLY 2737002A

PART NO.	DESCRIPTION	QTY. REQ'D
040084	STARTER	1
050027	PIPE, 1" SCR D X 1" HSE BARB PVC	6
050028	HOSE, VINYL, 1"	144 FT
050063	HOSE CLAMP, 1-3/4" X 5 X 445	12
050089	NIPPLE, 2" X 2" MNPT	1
050121	NIPPLE, 2-1/2" NPT X 10" LG	2
050122	COUPLING, 2-1/2" X 2-1/2"	1
050139	PIPE PLUG, 2" PVC	1
051051	PLUG, MALE 1/4"	1
051078	BALL VALVE, 1" PVC PIPE	6
051079	NIPPLE, PIPE, NYLON 1" X 1"	12
051089	ELBOW, 90°	3
051090	TY, 90°, 2-1/2 OD 16 GAUGE	1
051091	TUBING, MECHANICAL, 2-1/2" OD	28 FT
051094	ELBOW, 45°, 2-1/2" OD 16 GAUGE	2
051095	HANGER, TUBE, 2-1/2" OD 16 GAUGE	10
051096	ADAPTER, MALE, 2-1/2" X 2-1/2" T	1
051126	COUPLING, SLIP 2-1/2" X 3-1/2"	4
051131	TEE, 2-1/2" X 2-1/2" X 1" FNPT	1
051132	ELBOW, 90°, 2-1/2" X 2-1/2" FNPT	1
051142	MUFFLER M20	1
052041	NIPPLE, CLOSE, 2-1/2" X 2-1/2"	2
053081	GATE VALVE 2" NPT, BRONZE	1
090207	BLOWER, 10 HP 290S CFM 3.5 PSIG	1
090242	PRESSURE GAUGE	1
090243	VALVE, RELIEF	1
090248	FILTER ELEMENT	1
090257	FILTER	1
090258	ISOLATOR, FLOOR MOUNT	4
829881	SUPPORT, STAIRWAY	4
2737140	MANIFOLD, AIR, ANGLE BAR	2
2737370	BLOWER MOUNT / ANGLE BAR PACKAGE	2

DATE	REVISION	BY	CHK
01/11/12	1	WEB	WEB
01/11/12	2	WEB	WEB
01/11/12	3	WEB	WEB
01/11/12	4	WEB	WEB
01/11/12	5	WEB	WEB
01/11/12	6	WEB	WEB
01/11/12	7	WEB	WEB
01/11/12	8	WEB	WEB
01/11/12	9	WEB	WEB
01/11/12	10	WEB	WEB



NOTES:
 1. AT ASSEMBLY, USE SELF TAPPING SHEET METAL SCREWS TO SECURE TUBING
 2. SEE ASSEMBLY PARTS LIST 2737002
 3. SEE ASSEMBLY PARTS LISTS 2737002A, E, F, G & H OR 1712001A2, & A1
 PART NUMBER 051126 - SLIP COUPLING PROVIDED IF NEEDED
 PART NUMBER 051094 - 45 DEGREE ELBOW PROVIDED IF NEEDED

THIS DRAWING IS REPRESENTATIVE FOR IDENTIFICATION OF ACTUAL PARTS ONLY AND IS INCLUDED AS REFERENCE WHEN ORDERING REPLACEMENT PARTS FOR THE ATLAS 22-3/4" FOLDER. ALWAYS REFER TO THE PART NUMBERS WHEN ORDERING PARTS, INCLUDING THE SERIAL NUMBER OF THE FOLDER.

WEB PRESS, LLC
 701 EAST D ST., TACOMA, WA 98002

TOLERANCE (SEE NOTES)
 DECIMAL: 1/12
 FRACTIONAL: 1/12
 TITLE: PIPING ASSEMBLY: ANGLE BAR
 DATE: 01/11/12
 PART NUMBER: 2737002A

APPROVED BY: [Signature]

ATLAS FOLDER
OPTION: AIR LOADED ANGLE BAR IDLERS 2737002B

PART NO.	DESCRIPTION	QTY. REQ'D
001054	BEARING, ER-16X	72
511490	ROLLER CORE	20
515420	ROLLER CORE	16
733210	SHAFT, STIFFENER	16
2738150	SHAFT, STIFFENER	20

ATLAS FOLDER
OPTION: ANGLE BARS, ATLAS UNIT – M25 FOLDER 2737002C1

PART NO.	DESCRIPTION	QTY. REQ'D
1737090*	GUARD	1
2737410**	GUARD	1
1737071	STEP, PERFECTOR	1
2737251	STEP, FOLDER ANGLE BAR	1
2737321	PLATE, ANGLE BAR MOUNT	4

*Note: For 20" SPA Parts List 3518000B3 (Option)

**Note: For 36" SPA Parts List 3518000B6 (Standard)

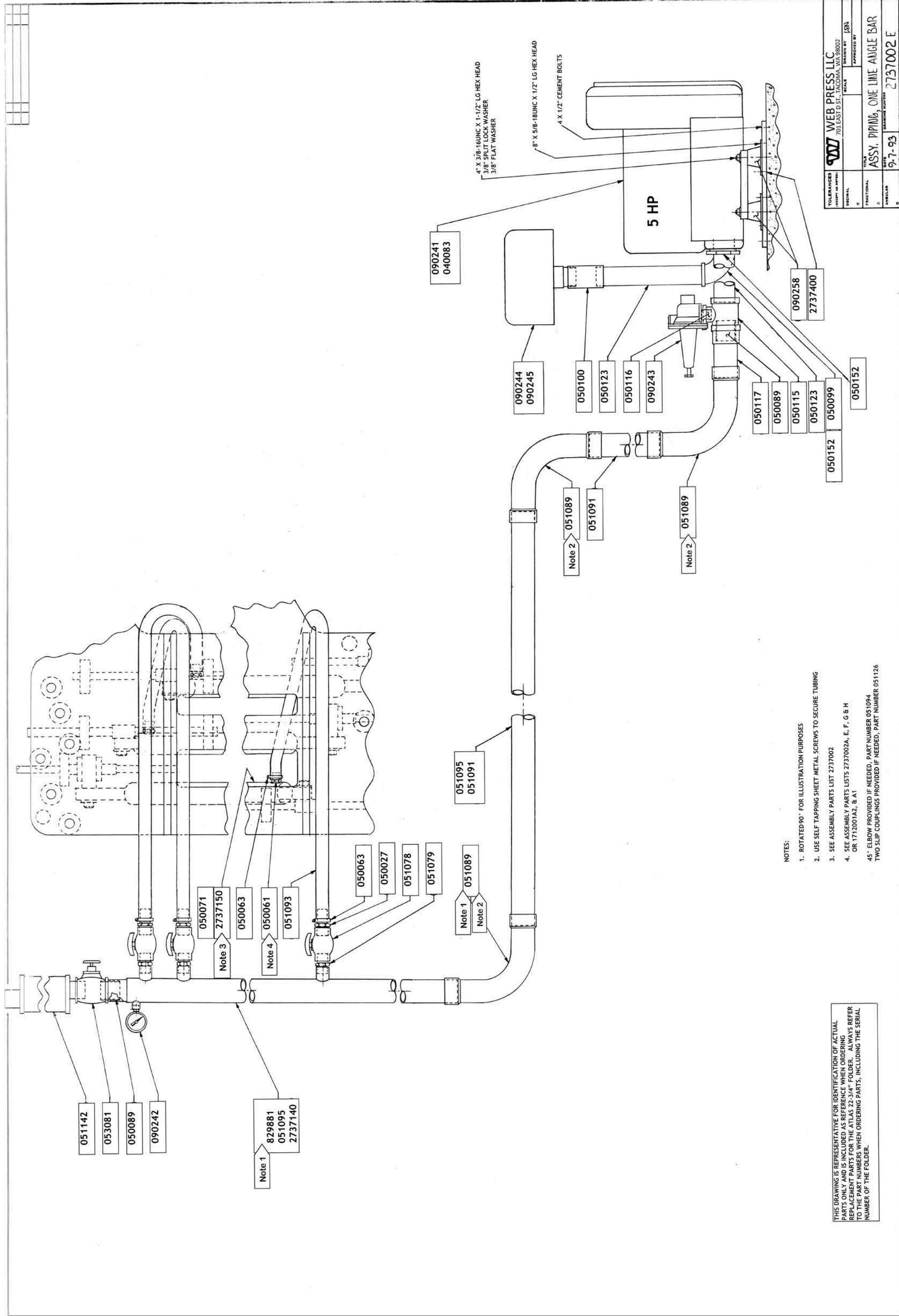
OPTION: ANGLE BARS, ATLAS UNIT – ATLAS FOLDER STANDARD
4'2" SPACING 2737002C2

1737071	STEP, PERFECTOR	1
1737080	STEP, FOLDER ANGLE BAR	1
2737321	PLATE, ANGLE BAR MOUNT	4
3518830	GUARD, EXTENDED DRIVE LINE	1

ATLAS FOLDER

OPTION: ANGLE BARS, LINE 1 PIPING ASSEMBLY – 5 HP BLOWER 2737002E

PART NO.	DESCRIPTION	QTY. REQ'D
040083	STARTER	1
050021	COUPLER, SLIP, 1" X 1" THREADED	3
050022	ELBOW, 90°, 1" SKT X 1" PVCBS2E	3
050027	PIPE, 1" SCR D X 1" HSE BARB PVC	3
050028	HOSE, VINYL 1"	216 FT
050063	HOSE CLAMP, 1-3/4" X 5 X 445	6
050071	PLUG, CHROME, 1"-11-1/2" NPT	3
050077	ELBOW, 3/4" NPT X 1" BARB	3
050089	NIPPLE, 2" X 2" MNPT	2
050099	ELBOW, 90° STREET, 2"	1
050100	COUPLING, 2" (SCHEDULE 40)	1
050115	TEE, 2" X 2" X 1" FNPT	1
050116	NIPPLE, MALE, 1" X 1"	1
050117	FITTING, SLIP, 2"FNPT X 2-1/2" OD, 16 GAUGE	1
050123	NIPPLE, 2" NPT X 10" LG	2
050152	REDUCER, 2-1/2" NPT X 2" NPT	2
051078	BALL VALVE, 1" PVC PIPE	3
051079	NIPPLE, PIPE, NYLON 1" X 1"	6
051089	ELBOW, 90°	3
051091	TUBING, MECHANICAL 2-1/2" OD	170 FT
051095	HANGER, TUBE, 2-1/2" OD, 16 GAUGE	5
051126	COUPLING, SLIP, 2-1/2" X 3-1/2"	2
051142	MUFFLER M20	1
053081	GATE VALVE, 2" NPT, BRONZE	1
090241	BLOWER, 5 HP	1
090242	PRESSURE GAUGE	1
090243	VALVE, RELIEF	1
090244	FILTER COVER	1
090245	FILTER ELEMENT	1
090258	ISOLATOR, FLOOR MOUNT	4
829881	SUPPORT, STAIRWAY	2
2737140	MANIFOLD, AIR, ANGLE BAR	1
2737400	BRACKET, FLOOR BLOWER MOUNT	2



TOLERANCES (EXCEPT AS NOTED)	WEB PRESS LLC 701 EAST D ST., TACOMA, WA 98002	DRAWN BY JSA
DIMENSIONAL	SCALE	APPROVED BY
FRACTIONAL		
DECIMAL		
ANGULAR		
	TITLE ASSY. PIPING, ONE LINE ANGLE BAR	DRAWING NUMBER 2737002 E
		9-7-93

- NOTES:
1. ROTATED 90° FOR ILLUSTRATION PURPOSES
 2. USE SELF TAPPING SHEET METAL SCREWS TO SECURE TUBING
 3. SEE ASSEMBLY PARTS LIST 2737002
 4. SEE ASSEMBLY PARTS LISTS 2737002A, E, F, G & H OR 1712001A2, & A1
 - 45° ELBOW PROVIDED IF NEEDED, PART NUMBER 051094
TWO SLIP COUPLINGS PROVIDED IF NEEDED, PART NUMBER 051126

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ATLAS FOLDER

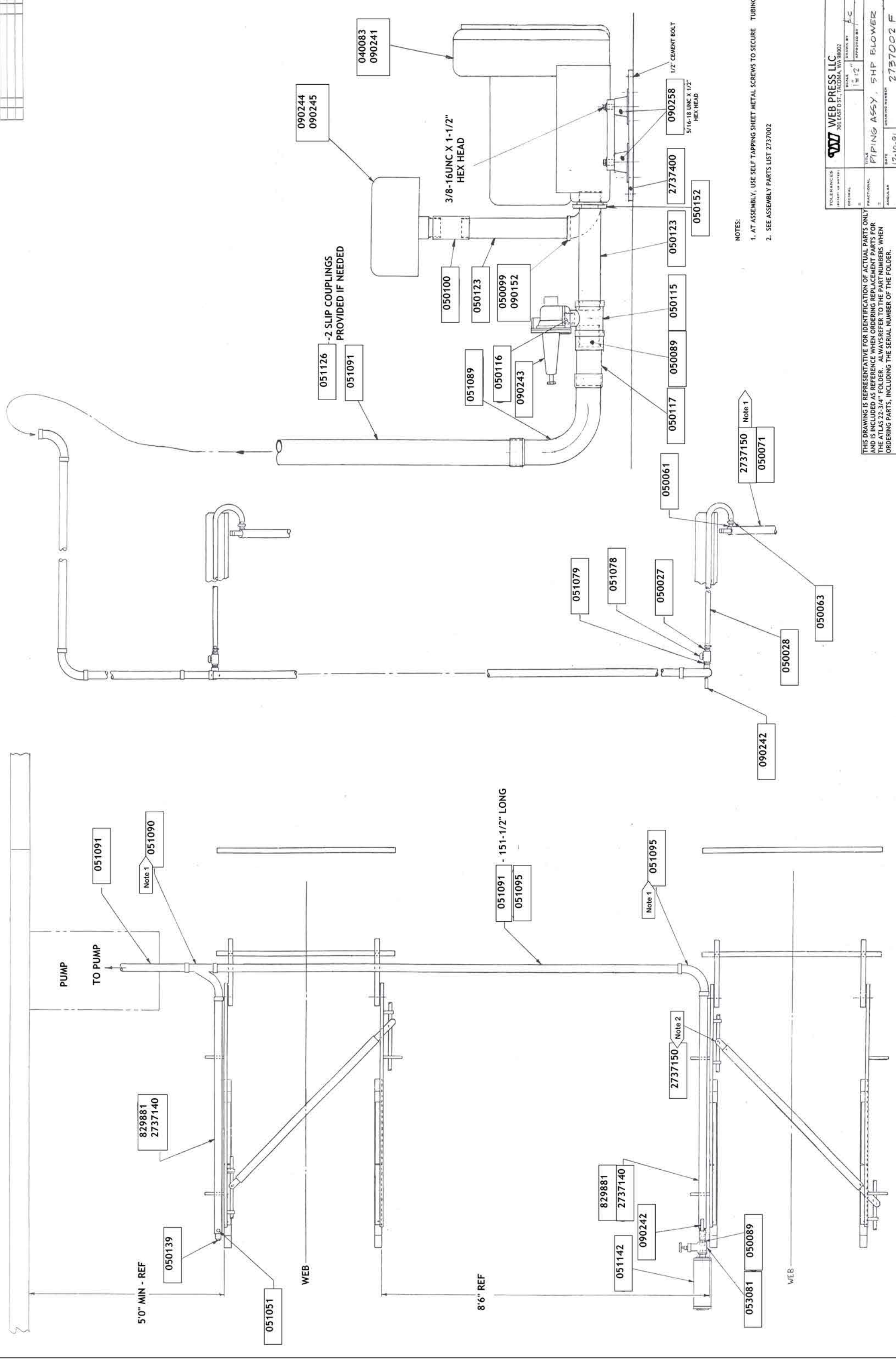
OPTION: ANGLE BARS, TWIN LINE WITH ONE BAR PIPING ASSEMBLY – 5 HP BLOWER 2737002F

PART NO.	DESCRIPTION	QTY. REQ'D
040083	STARTER	1
050022	ELBOW, 90° 1" SKT X 1" PVCS2E	4
050027	PIPE, 1" SCR D X 1" HSE BARB PVC	2
050028	HOSE, 1" VINYL	96 FT
050061	ADAPTER, HOSE, 3/4" PIPE X 1" BARB	2
050063	HOSE CLAMP, 1-3/4" X 5 X 445	4
050071	PLUG, 1"-11-1/2" NPT (CHROME)	3
050077	ELBOW, 3/4" NPT X 1" BARB	2
050089	NIPPLE, 2" X 2" MNPT	2
050099	ELBOW, 90° STREET, 2"	1
050100	COUPLING, 2" (SCHEDULE 40)	1
050115	TEE, 2" X 2" X 1" FNPT	1
050116	NIPPLE, 1" X 1" MNPT	1
050117	FITTING, SLIP, 2" FNPT X 2-1/2" OD	1
050123	NIPPLE, 2" NPT X 10" LG	2
050139	PLUG, PIPE, 2" PVC	1
050152	REDUCER, 2-1/2" NPT X 2" NPT	2
051051	PLUG, MALE 1/4"	1
051078	BALL VALVE, 1" PVC PIPE	2
051079	NIPPLE, PIPE, 1" X 1" NYLON	4
051089	ELBOW, 90°	3
051090	TY, 90°, 2-1/2" OD, 16 GAUGE	1
051091	TUBING, MECHANICAL, 2-1/2" OD	336 FT
051095	HANGER, TUBE, 2-1/2" OD 16 GAUGE	6
051126	COUPLING, SLIP 2-1/2" X 3-1/2"	2
051142	MUFFLER, M20	1
053081	GATE VALVE, 2" NPT BRONZE	1
090241	BLOWER, 5 HP	1
090242	PRESSURE GAUGE	1
090243	VALVE, RELIEF	1
090244	FILTER COVER	1

ATLAS FOLDER

**OPTION: ANGLE BARS, TWIN LINE WITH ONE BAR PIPING
ASSEMBLY – 5 HP BLOWER 2737002F (CONTINUED)**

PART NO.	DESCRIPTION	QTY. REQ'D
090245	FILTER ELEMENT	1
090258	ISOLATOR, FLOOR MOUNT	4
829881	SUPPORT, STAIRWAY	4
2737140	MANIFOLD, AIR, ANGLE BAR	2
2737400	BRACKET, FLOOR BLOWER MOUNT	2



090244
090245

040083
090241

3/8-16UNC X 1-1/2"
HEX HEAD

090258
5/16-18 UNC X 1/2"
HEX HEAD

2737400

050152

051126
051091
-2 SLIP COUPLINGS
PROVIDED IF NEEDED

050100

050123

050099
090152

051089

050116

090243

050123

050115

050089

050117

050061

051079

051078

050027

Note 1
2737150

050071

050028

050063

090242

051091

Note 1
051090

PUMP
TO PUMP

829881
2737140

5'0" MIN - REF
050139

051051

WEB

051091 - 151-1/2" LONG
051095

8'6" REF

Note 1
051095

Note 2
2737150

829881
2737140

051142

090242

053081

050089

WEB

NOTES:

1. AT ASSEMBLY, USE SELF TAPPING SHEET METAL SCREWS TO SECURE TUBING
2. SEE ASSEMBLY PARTS LIST 2737002

TOLERANCES FRACTIONAL		SCALE 1" = 12"		DRAWN BY J.C.	
ORIGINAL		DATE 17-10-91		DESIGNING NUMBER 2737002 F	
FRACTIONAL		TITLE PIPING ASSY, 5HP BLOWER		APPROVED BY	

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ATLAS FOLDER

OPTION: ANGLE BARS, TWIN LINE WITH DROOP SNOOT AIR FORMER PIPING ASSEMBLY – 10 HP BLOWER 2737002G

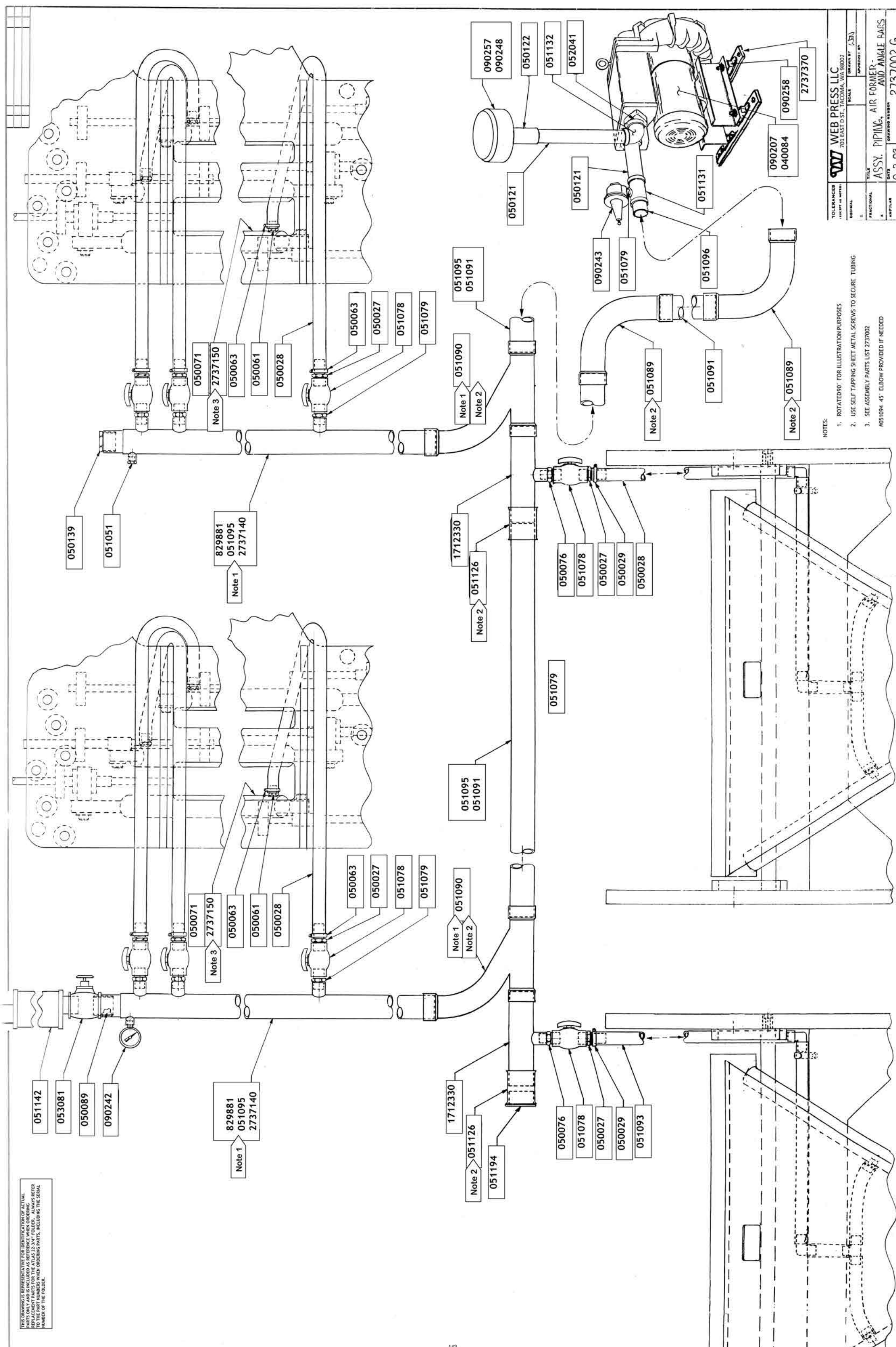
PART NO.	DESCRIPTION	QTY. REQ'D
040084	STARTER	1
050027	PIPE, 1" SCR D X 1" HSE BARB PVC	8
050028	HOSE, 1" VINYL	672 FT
050029	HOSE CLAMP, 1" X 5 X 444	2
050061	ADAPTER, HOSE, 3/4" PIPE X 1" BARB	6
050063	HOSE CLAMP, 1-3/4" X 5 X 445	12
050071	PLUG, 1"-1 1/2" NPT (CHROME)	7
050076	NIPPLE, 1" X 3/4"	2
050089	NIPPLE, 2" X 2" MNPT	1
050121	NIPPLE, 2-1/2" NPT X 10" LG	2
050122	COUPLING, 2-1/2" X 2-1/2"	1
050139	PLUG, PVC PIPE, 2"	1
051051	PLUG, MALE, 1/4"	1
051078	BALL VALVE, 1" PVC PIPE	8
051079	NIPPLE, PIPE, NYLON 1" X 1"	7
051089	ELBOW, 90°	2
051090	TY, 90°, 2-1/2" OD, 16 GAUGE	2
051091	TUBING, MECHANICAL 2-1/2" OD	336 FT
051094	ELBOW, 45°, 2-1/2" OD 16 GAUGE	2
051095	HANGER, TUBE, 2-1/2" OD 16 GAUGE	10
051096	ADAPTER, MALE 2-1/2" X 2-1/2" T	1
051126	COUPLING, SLIP, 2-1/2" X 3-1/2"	4
051131	TEE, 2-1/2" X 2-1/2" X 1" FNPT	1
051132	ELBOW, 90°, 2-1/2" X 2-1/2" FNPT	1
051142	MUFFLER M20	1
051194	PLUG, TUBE, 2-1/2" OD X 1-3/8"	1
052041	NIPPLE, CLOSE, 2-1/2" X 2-1/2"	2
053081	GATE VALVE, 2" NPT BRONZE	1
090207	BLOWER, 10 HP 290S CFM 3.5 PSIG	1
090242	PRESSURE GAUGE	1
090243	VALVE, RELIEF	1
090248	FILTER ELEMENT	1

ATLAS FOLDER

**OPTION: ANGLE BARS, TWIN LINE WITH DROOP SNOOT AIR
FORMER PIPING ASSEMBLY – 10 HP BLOWER 2737002G (CONTINUED)**

PART NO.	DESCRIPTION	QTY. REQ'D
090257	FILTER	1
090258	ISOLATOR, FLOOR MOUNT	4
829881	SUPPORT, STAIRWAY	4
1712330	MANIFOLD, AIR	2
2737140	MANIFOLD, AIR, ANGLE BAR	2
2737370	BLOWER MOUNT, ANGLE BAR PACKAGE	2

THIS DRAWING IS REPRESENTATIVE FOR IDENTIFICATION OF ACTUAL REPLACEMENT PARTS FOR THE ATLAS 32.30T FOLDER. ALWAYS REFER TO THE PART NUMBERS WHEN ORDERING PARTS, INCLUDING THE SERIAL NUMBER OF THE FOLDER.



051142
053081
050089
090242

829881
051095
2737140
Note 1

050071
2737150
Note 3
050063
050061
050028

050063
050027
051078
051079

Note 1
051090
Note 2
051095
051091

1712330
Note 2
051126
051194

050076
051078
050027
050029
051093

050139
051051

829881
051095
2737140
Note 1

050071
2737150
Note 3
050063
050061
050028

050063
050027
051078
051079

Note 1
051090
Note 2
051095
051091

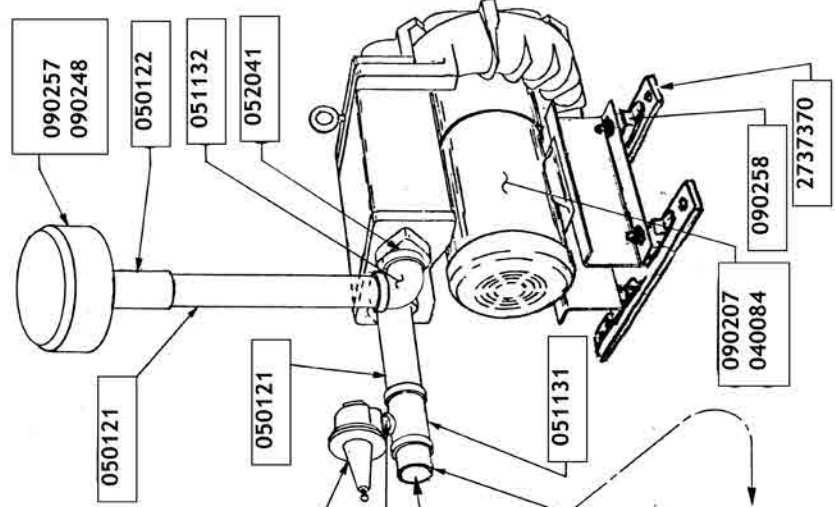
1712330
Note 2
051126

050076
051078
050027
050029
050028

Note 2
051089

051091

Note 2
051089



NOTES:
1. ROTATED 90° FOR ILLUSTRATION PURPOSES
2. USE SELF TAPPING SHEET METAL SCREWS TO SECURE TUBING
3. SEE ASSEMBLY PARTS LIST 2737002
#051094 45° ELBOW PROVIDED IF NEEDED

TOLERANCES UNLESS NOTED		WEB PRESS LLC 701 EAST D ST., FREDONIA, VA 28602	
ORIGINAL	DATE	DESIGNED BY	APPROVED BY
FRACTIONAL			
DECIMAL			
APPLICABLE			
TITLE ASSY. PIPING, AIR FORMER- AND ANGLE BARS		DRAWING NUMBER 2737002 G	
DATE 9-2-93			

ATLAS FOLDER

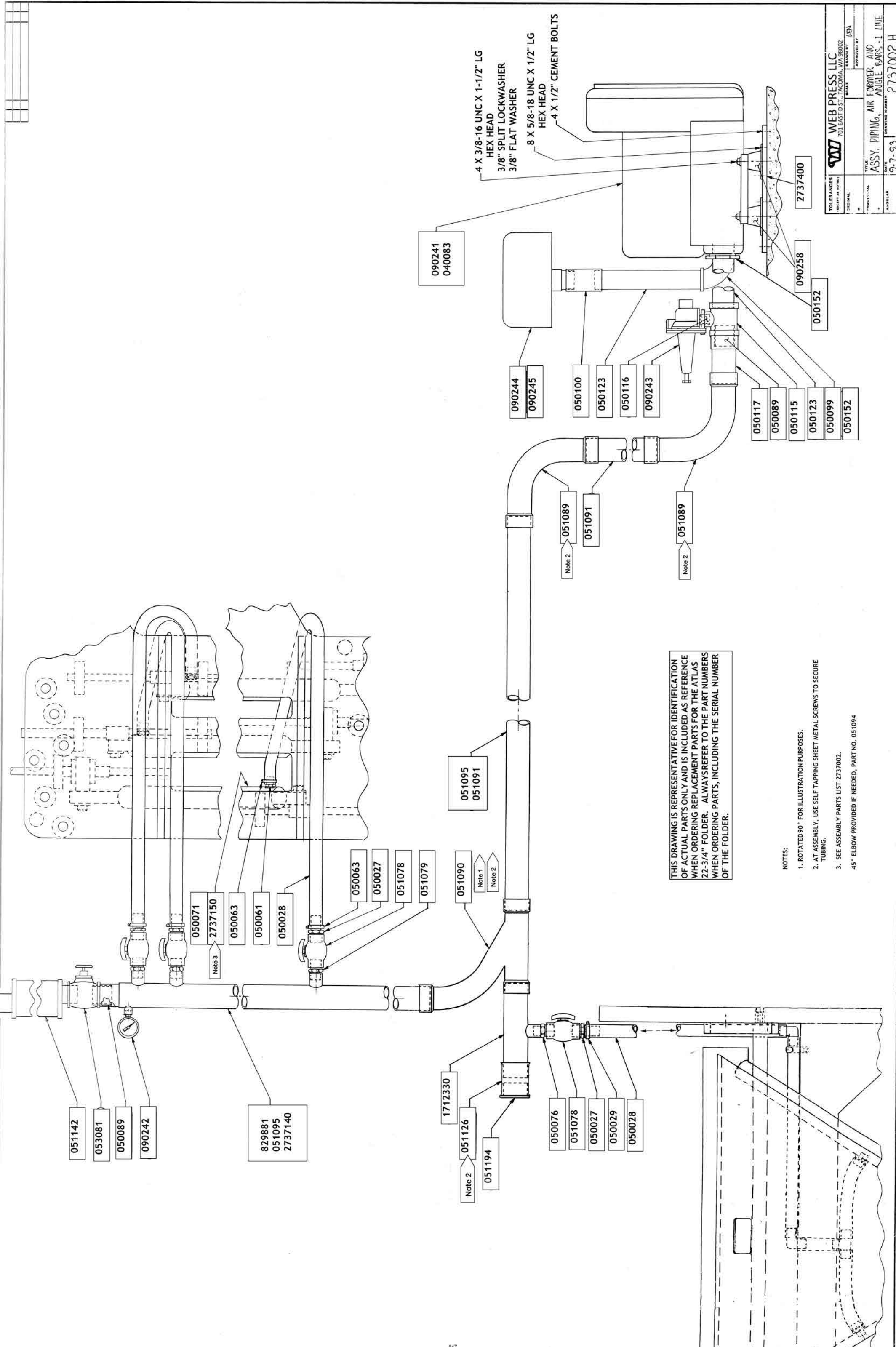
OPTION: ANGLE BARS, ONE LINE WITH DROOP SNOOT AIR FORMER PIPING ASSEMBLY – 5 HP BLOWER 2737002H

PART NO.	DESCRIPTION	QTY. REQ'D
040083	STARTER	1
050027	PIPE, 1" SCRD X 1" HSE BARB PVC	4
050028	HOSE, 1" VINYL	216 FT
050029	HOSE CLAMP, 1" 5 X 444	1
050061	ADAPTER, HOSE, 3/4" PIPE X 1" BARB	3
050063	HOSE CLAMP, 1-3/4" X 5 X 445	6
050071	PLUG, 1"-11-1/2" NPT (CHROME)	3
050076	NIPPLE, 1" X 3/4"	1
050089	NIPPLE, 2" X 2" MNPT	2
050099	ELBOW, 90° , 2" STREET	1
050100	COUPLING, 2" (SCHEDULE 40)	1
050115	TEE, 2" X 2" X 1" FNPT	1
050116	NIPPLE, 1" X 1" MNPT	1
050117	FITTING, SLIP , 2" FNPT X 2-1/2" OD	1
050123	NIPPLE, 2" NPT X 10" LG	2
050152	REDUCER, 2-1/2" NPT X 2" NPT	2
051078	BALL VALVE, 1" PVC PIPE	4
051079	NIPPLE, 1" PIPE, X 1" NYLON	3
051089	ELBOW, 90°	2
051090	TY, 90°, 2-1/2" OD 16 GAUGE	1
051091	TUBING, MECHANICAL, 2-1/2" OD	240 FT
051095	HANGER, TUBE, 2-1/2" OD 16 GAUGE	5
051126	COUPLING, SLIP, 2-1/2" X 3-1/2"	2
051142	MUFFLER, M20	1
051194	PLUG, 2-1/2" OD TUBE X 1-3/8"	1
053081	GATE VALVE, 2" NPT BRONZE	1
090241	BLOWER, 5 HP	1
090242	PRESSURE GAUGE	1
090243	VALVE, RELIEF	1
090244	FILTER COVER	1
090245	FILTER ELEMENT	1

ATLAS FOLDER

**OPTION: ANGLE BARS, ONE LINE WITH DROOP SNOOT AIR FORMER
PIPING ASSEMBLY – 5 HP BLOWER 2737002H (CONTINUED)**

PART NO.	DESCRIPTION	QTY. REQ'D
090258	ISOLATOR, FLOOR MOUNT	4
829881	SUPPORT, STAIRWAY	2
1712330	MANIFOLD, AIR	1
2737140	MANIFOLD, AIR, ANGLE BAR	1
2737400	BRACKET, FLOOR BLOWER MOUNT	2



THIS DRAWING IS REPRESENTATIVE FOR IDENTIFICATION
 OF ACTUAL PARTS ONLY AND IS INCLUDED AS REFERENCE
 WHEN ORDERING REPLACEMENT PARTS FOR THE ATLAS
 22-3/4" FOLDER. ALWAYS REFER TO THE PART NUMBERS
 WHEN ORDERING PARTS, INCLUDING THE SERIAL NUMBER
 OF THE FOLDER.

- NOTES:
1. ROTATED 90° FOR ILLUSTRATION PURPOSES.
 2. AT ASSEMBLY, USE SELF TAPPING SHEET METAL SCREWS TO SECURE TUBING.
 3. SEE ASSEMBLY PARTS LIST 2737002.
- 45° ELBOW PROVIDED IF NEEDED, PART NO. 051094

TOLERANCES EXCEPT AS NOTED	SCALE	DATE	APPROVED BY
DRAWING NO.	2737002 H	9-7-93	JEN
FILE NO.	ASSY. PIPING, AIR FORMER AND ANGLE BARS - 1 LINE		
WEB PRESS LLC 701 EAST D ST., TACOMA, WA 98002			



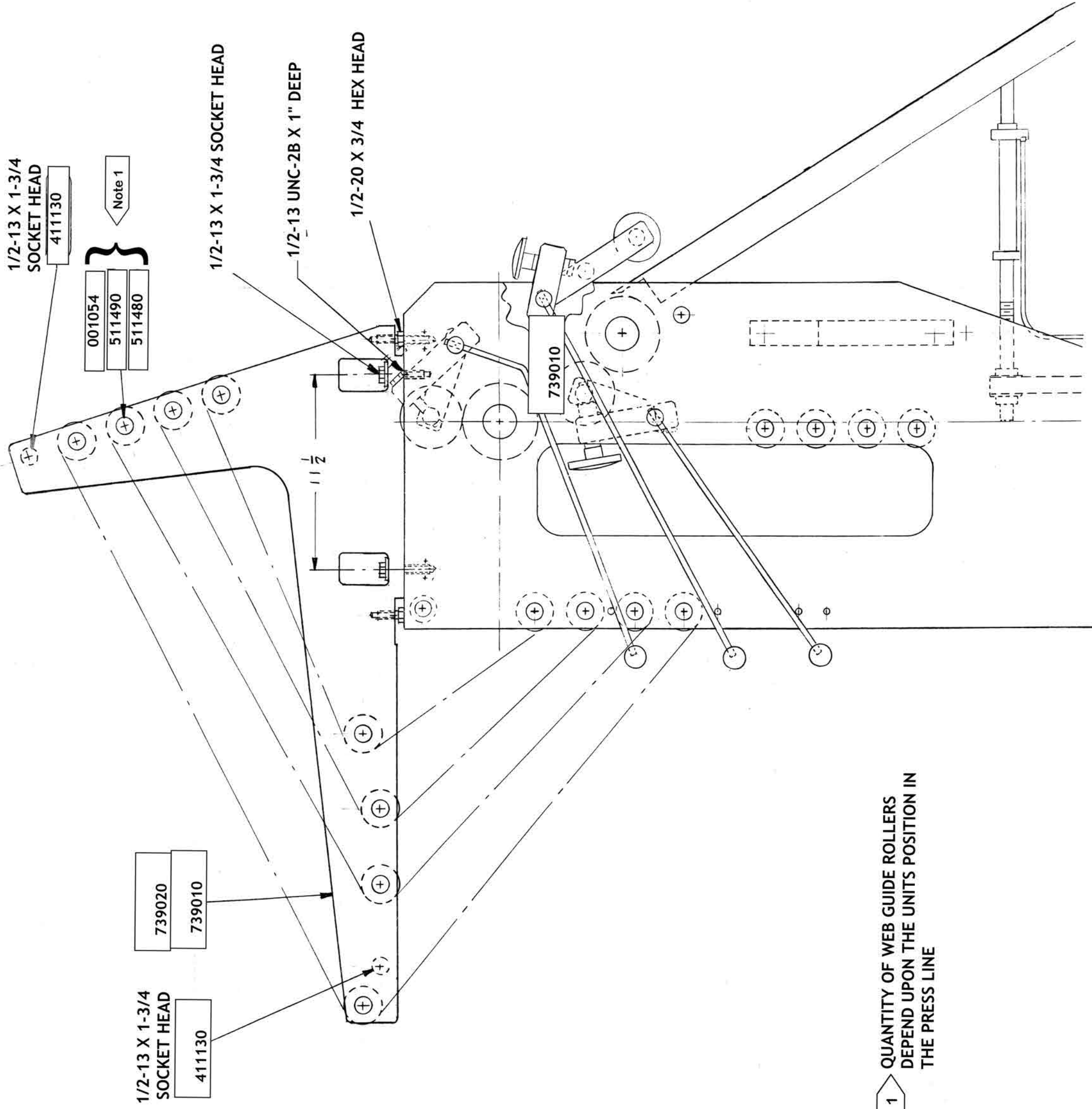
Over Folder Lead

**ATLAS FOLDER
OVER FOLDER LEAD BRACKET 739000**

PART NO.	DESCRIPTION	QTY. REQ'D
001054*	BEARING, ER-16X	2
411130	SHAFT, STIFFENER	2
511480*	SHAFT, STIFFENER	1
511490*	ROLLER CORE	1
739010	ARM, OVER FOLDER LEAD ASSEMBLY	1
739020	ARM, OVER FOLDER LEAD ASSEMBLY	1

*Note: Quantity of Web Guide Rollers depends on each units' position in Pressline.

DATE	SYM	REVISION RECORD	DR. CK.



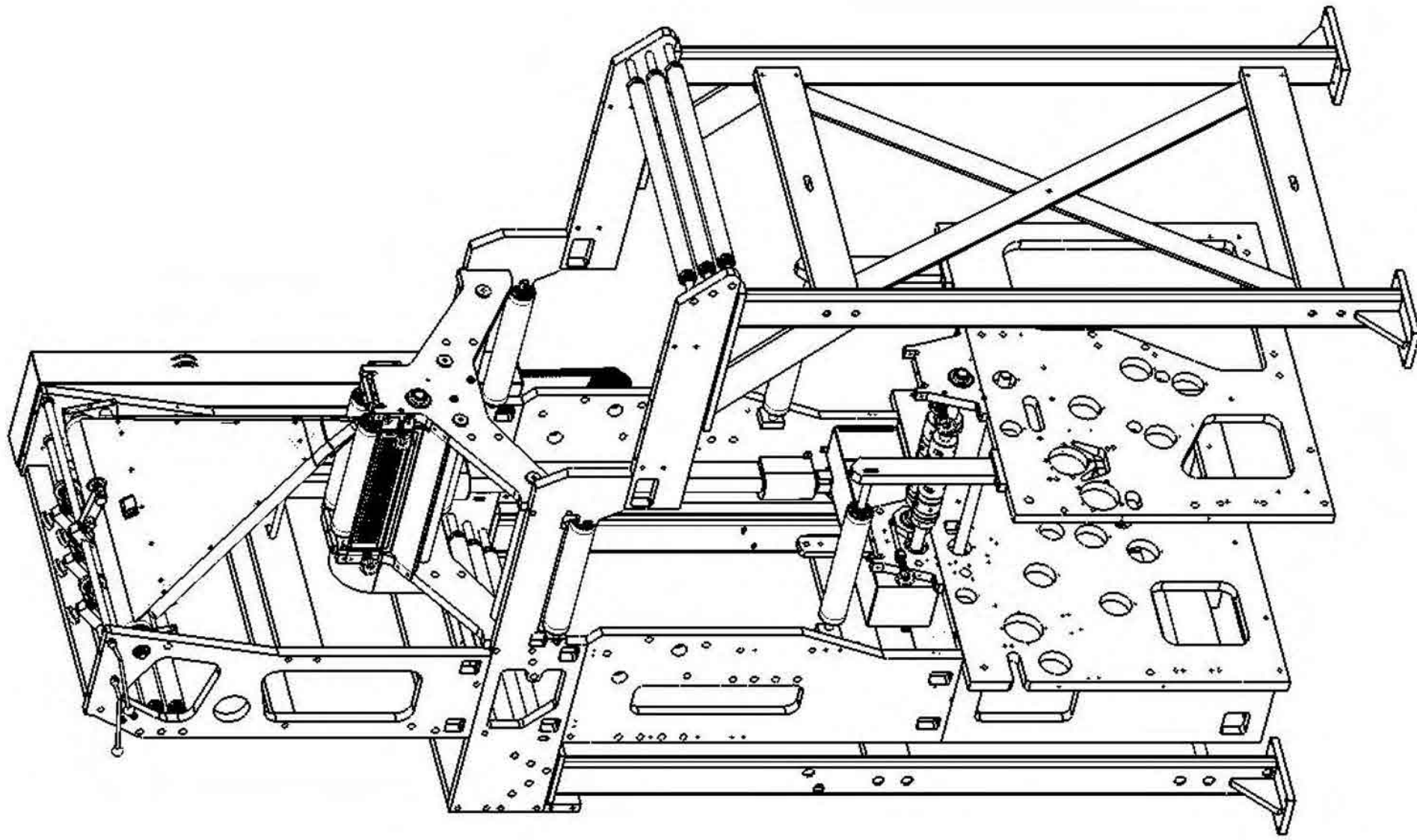
Note 1
 QUANTITY OF WEB GUIDE ROLLERS
 DEPEND UPON THE UNITS POSITION IN
 THE PRESS LINE

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 PARTS FOR THE ATLAS
 22-3/4" FOLDER.
 ALWAYS REFER TO THE

TOLERANCES (EXCEPT AS NOTED)	WEB PRESS LLC 701 EAST D ST., TACOMA, WA 98002		
DECIMAL	±	SCALE	1/4:1
FRACTIONAL	±	DRAWN BY	PC
ANGULAR	±	TITLE	ATLAS OVER FOLDER LEADS
		DATE	12-1-92
		DRAWING NUMBER	739000
		APPROVED BY	



Upper Former Assemblies



DATE	SYM	REVISION RECORD	DR	CK
6/29/05	A	NEW RELEASE	GV	

ASSEMBLIES INCLUDED:
 1619003 - UPPER FORMER -LINE 1
 1619003C - OPTION: WALKWAY - SINGLE LINE
 1619003F- OPTION: UPER FORMER OVER FOLDER LEAD
 1619003G- UPPER FORMER UNDER FOLDER LEAD

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TITLE **BALLOON FORMER**

DRAWN:	SIZE	DWG. NO.	SHEET	OF	REV.
G VARGAS	B	1620810	1	1	A
MODELED BY:	SCALE:	DATE:			
GV	1:20	6/29/05			

TOLERANCES (EXCEPT AS SHOWN)	
FRACTIONAL	± 1/32
DECIMALS	.XX ± .01 .XXX ± .005
ANGLES	± 1°
DO NOT SCALE DRAWING	

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ATLAS FOLDER
UPPER FORMER LOWER FORMER PREFORM AND NIP ROLL
1619001A

PART NO.	DESCRIPTION	QTY. REQ'D
A1282-16	PULLEY SHAFT	1
001001	BEARING, ER-16	1
001009	BEARING, ER-24	3
008004	ROD END, 3/8" ID X 38-24 MALE	2
021004	SPRING, 5/8" X 4" LG (BLUE)	2
032004	SET COLLAR, 1/2" X 1"	2
060025	BELT, 1/2"P X 1"W X 63" LG	1
061041	BUSHING, 20T X 1/2P X 1" W TYPE EF WITH TAPER BUSHING	2
062036	TAPER BUSHING, 1/-1/2 20 BORE	2
069001	RINGFEDER, 38 X 44	4
069012	SHAFT, IDLER 1" DIAMETER X 2-1/8"	1
069013	PULLEY, IDLER, 4" DIAMETER, 1" HOLE	1
069018	BRACKET, IDLER	1
613160	GEAR, CAP NIP ROLL	1
613170	KNOB, NIP ROLL ADJUST	2
1613080	SPACER, PINCH ROLL	2
1613090	SPACER, PINCH ROLL	2
1613112	GEAR, NIP ROLL (RIGHT)	1
1613121	GEAR, NIP ROLL (LEFT)	1
1613131	CAP, NIP ROLL GEAR	1
1613141	NIP ROLL, HALF-FOLD (ATLAS)	3
1619221*	PLATE, RISER, OPERATOR SIDE	1
1619231**	PLATE, RISER, GEAR SIDE	1
1619280	PLATE, OPERATOR SIDE, NIP ROLL SWING HALF-FOLD	1
1619290	PLATE, GEAR SIDE, NIP ROLL SWING	1

*Note: Replaces 713242, Parts List 1713000

**Note: Replaces 713232, Parts List 1713000

ATLAS FOLDER
UPPER FORMER LOWER FORMER PREFORM AND NIP ROLL
1619001A

CONTINUED

PART NO.	DESCRIPTION	QTY. REQ'D
1619340	ROD, NIP ROLL ADJUST	2
1619390***	SHAFT	2
1619490****	PLATE, PRE-FOR ADJUST	1
1619570	ROD, NIP ROLL ADJUST	2
1619810	SHAFT, NIP ROLL	1

***Note: Replaces 1613060

****Note: Replaces 713220

OPTION: UPPER FORMER NIP WITHOUT PERFORATOR
1619001A1

1613080	SPACER, PINCH ROLL	4
1613090	SPACER, PINCH ROLL	4
1613141	NIP ROLL, ATLAS HALF-FOLD	2

OPTION: UPPER FORMER NIP WITH PERFORATOR 1619001A2

1613271	SPACER, PINCH ROLL	3
1613280	SPACER, PINCH ROLL	2
2723110	NIP ROLL, HALF-FOLD CROSS PERFORATOR	1

OPTION: UPPER FORMER SLITTER ASSEMBLY 1619001A3

001054	BEARING, ER-16X	1
032003	SET COLLAR, 1" X 1-5/8"	2
033003	KNOB, 3-1/8" DIAMETER X 1/2-13	1
035005	THUMB SCREW, 1/2-13 X 3-1/2" LG	1
090004	SLITTER WHEEL, WITH BEARING	1
611240	SHAFT, TROLLEY	1
611260	BRACKET, SLITTER CLAMP	1
611290	SCREW, SLITTER ADJUST	1
611320	ARM, SLITTER	1
611330	AXLE, SLITTER	1
611340	STUD SPACER, ANVIL SLITTER	1
611350	BEARING STUD, SLITTER ANVIL	1

ATLAS FOLDER

OPTION: UPPER FORM DISCONNECT 1619001B1

001058	BEARING, 9107 KDD	2
9-1184-1	MOUNTING SLEEVE	1
9-1184-2	PULLEY	1
9-1184-3	COUPLING	1
9-1184-4	SPACER	1

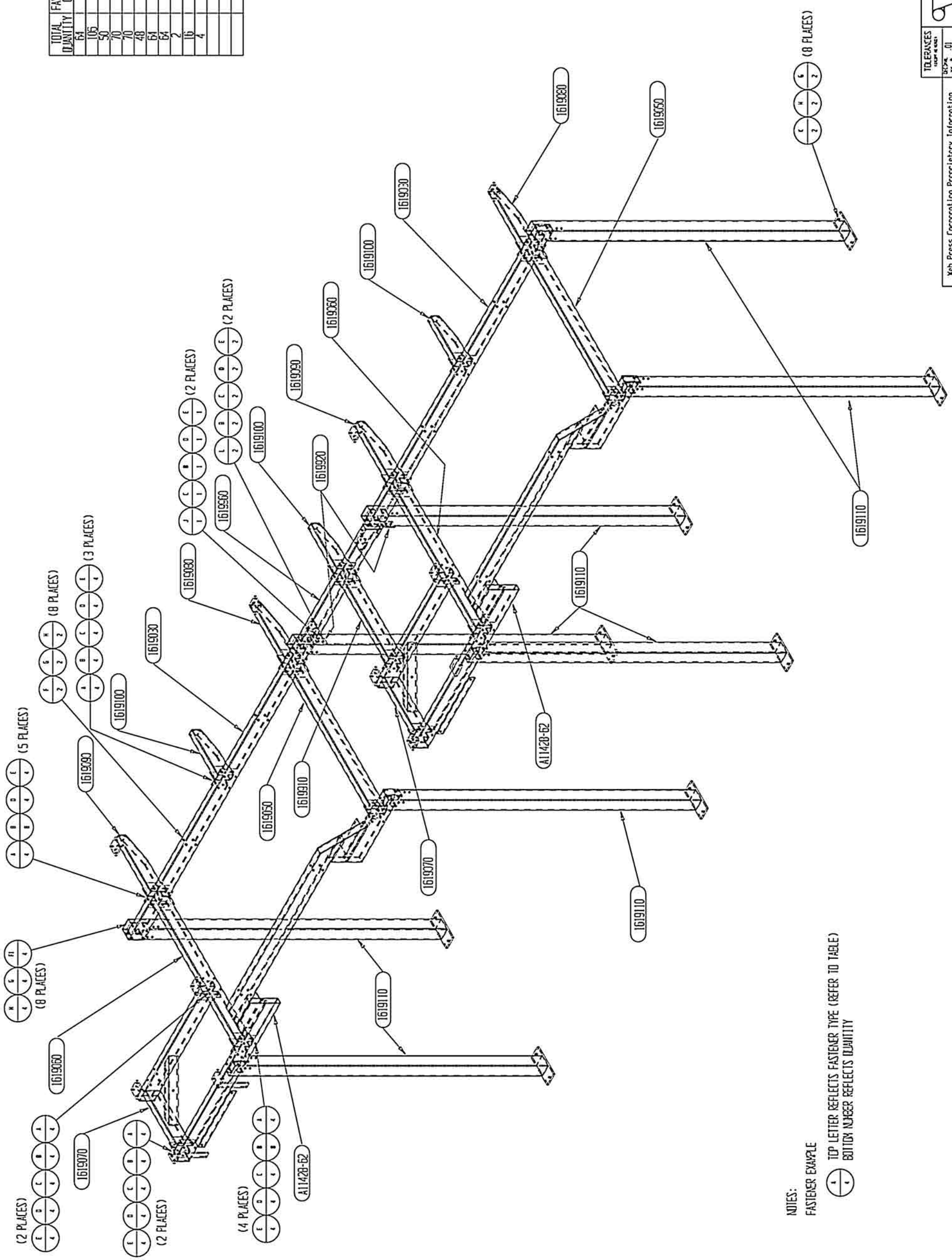
ATLAS FOLDER
OPTION: UPPER FORMER PLATFORMS 1619001D

A1142B63	LADDER	2
A1142B59	ADAPTER, FLANGE MOUNT	6
A1142B60*	DECK PLATE WALKWAY (LADDER)	2
A1142B62	SUPPORT, PLATFORM	2
A1482-22	BRACKET, LADDER SUPPORT	2
090088	ELBOW, #3, 1-1/4"	8
090089	FITTING, "T", SOLID #5, 1-1/4" 4B	8
090090	FITTING, CROSS, #7, 1-1/4"	8
090091	OUTLET, SIDE #9, 1-1/4" 4C	8
090092	OUTLET, SIDE #11, 1-1/4" 4C	8
090093	FLANGE, FLOOR #45, 1-1/4" 4C	16
090094	PIPE, 1-1/4"ID X 1.660OD ALUMINUM	220 FT
714270	SHIM, BALLOON FORMER	8
714280	SHIM, BALLON FORMER	8
1619030	SUPPORT, PLATFORM	2
1619040	SUPPORT, PLATFORM	2
1619050	TIE ROD	2
1619060	TIE ROD	2
1619070	SUPPORT, PLATFORM	2
1619080	BALLOON, PLATFORM SUPPORT	2
1619090	BALLOON, PLATFORM SUPPORT	2
1619100	BALLOON, PLATFORM SUPPORT	3
1619110	POSTS, SUPPORT	8
1619150	WALKWAY	2
1619160	WALKWAY	2
1619910	TIE ROD	1
1619920	SUPPORT, TIE BAR	2
1619940	WALKWAY	1
1619950	WALKWAY	1
1619960	PLATFORM	1
1619970	WALKWAY	1

*Note: Replaces 1619180 & 1619930

DATE	SYN	REVISION	REC'D	DR.	CK.

TOTAL QUANTITY	FASTENER CODE	FASTENER DESCRIPTION
64	A	3/8-16 UNC X 3 1/2 LG SOCKET HEAD CAP SCREW
105	B	3/8 DIA. BEVELLED STRUT TUBULAR WASHER
50	C	3/8 DIA. FLAT STRUT WASHER
70	D	3/8 DIA. HELICAL LOCK WASHER
70	E	3/8-16 UNC X 3" LG SOCKET HEAD CAP SCREW
48	F	1/2-13 UNC X 3" LG SOCKET HEAD CAP SCREW
64	G	1/2 DIA. HELICAL LOCK WASHER
64	H	1/2 DIA. FLAT STRUT WASHER
2	J	3/8-16 UNC X 5 3/4 LG SOCKET HEAD CAP SCREW
16	K	1/2 LENGTH TAG BOLTS
4	L	3/8-16 UNC X 4 3/4 LG SOCKET HEAD CAP SCREW



NOTES:
 FASTENER EXAMPLE
 (A 1) TOP LETTER REFLECTS FASTENER TYPE (REFER TO TABLE)
 (1) BOTTOM NUMBER REFLECTS QUANTITY

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TOLERANCES
 UNLESS OTHERWISE SPECIFIED

SIZE	± .01
ANGLE	± .01
FUNCTIONAL	± .01
FINISH	± .01
WELD	± .01
DRILL	± .01

DATE: 11-4-94
 SCALE: XXXXX
 DRAWN BY: M. E. N.
 APPROVED BY: XXXXXXXXXXXX

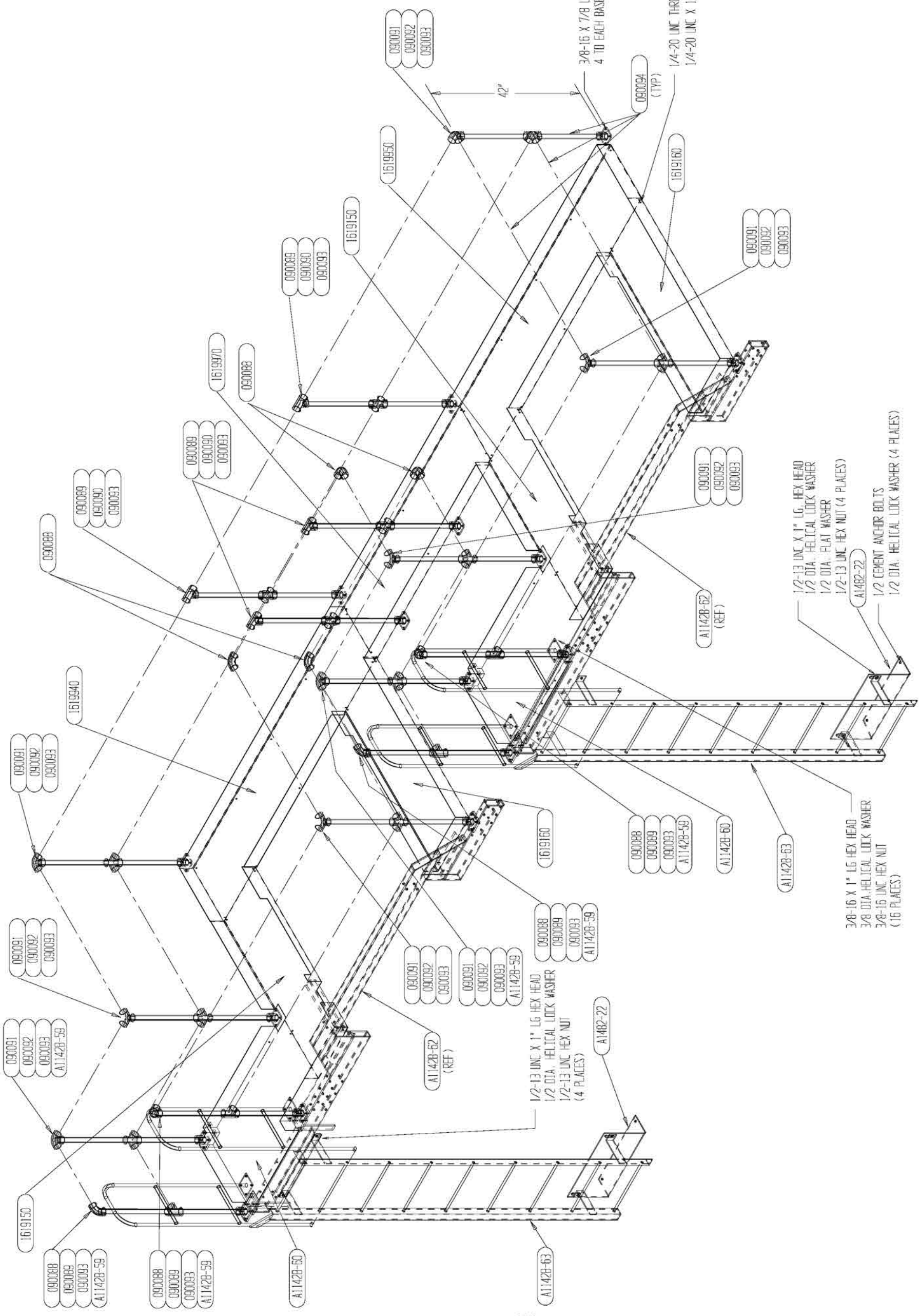
WEB PRESS LLC
 701 EAST D ST., YACOMMA, WA 98002

UPPER PLATFORM (TWINNED)

FIG. NO. 1619010 SHIT 1 OF 2
 SCALE XXXXX
 DATE 11-4-94
 SIDE C
 KEY -

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DATE	SYM	REVISION RECORD	DR.	CHK.



1661

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TOLERANCES UNLESS NOTED	DECIMAL	± .01
FRAC. DIA.	± .001	
ANGLE	± 1/2°	
FINISH	± 1 Deg	

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UPPER PLATFORM (TWINNED)

DRAWN BY: W. E. N.
 APPROVED BY: XXXXXXXXXXXX

DATE: XXXXX
 SCALE: XXXXX
 SHEET: 11-7-54
 OF: 2

FIG. NO.: 16190010.SHT 2 OF 2

ATLAS FOLDER
OPTION: NIP GUARDS 1619001E

PART NO.	DESCRIPTION	QTY. REQ'D
090312	LATCH, MAGNETIC	9
261290	GUARD, DOOR	1
2619220	GUARD, MOTOR	1
2619230	GUARD, VERITICAL NIP	1
2619240	MOUNT, NIP GUARD, GEAR SIDE	1
2619310	NIP GUARD WELDMENT ASSEMBLY	2
2619340	MOUNT-LATCH, GEAR SIDE	2
2619350	SPACER	10
2619360	MOUNT-LATCH, OPERATOR SIDE	1
2619370	REST, HALF-FOLD GUARD	2
2619380	GUARD, HALF-FOLD	1
2619390	GUARD MOUNT, HALF FOLD	1
2619400	GUARD, NIP	1
2619410	GUARD, NIP ADJUST	2
2619420	MOUNT-LATCH, OPERATOR SIDE	1

ATLAS FOLDER
OPTION: UPPER NIP GUARDS 1619001E1

041002	SWITCH, MICRO BZE6-2RQ62	2
051017	TUBING, 3/8"OD	15 FT
051044	CLAMPS, FEED LINE	5
051051	PLUG, 1/4" MALE	1
051195	FITTING, "T", 1/4" X 1/4" (SCP)	1
053018	TUBE, 1/8" STEEL	10 FT
053024	CLAMP, 1/8" TUBING	5
053028	INJECTOR, SL-32 SERIES	1
053032	CONNECTOR, MALE, 3/8"T X 1/4"NPT	1
053043	PLUG, CLOSURE	2
053068	FERRULE, 1/8"	6
053069	FERRULE, 3/8"	6
090057	LATCH, MAGNETIC	1
1619891	GUARD, UPPER NIPS	1
1619901	GUARD, UPPER NIPS	1
2612341	FOLDER, SWITCHMOUNT	2

ATLAS FOLDER
OPTION: UPPER PREFORM & NIP ROLL 1619002A

PART NO.	DESCRIPTION	QTY. REQ'D
001001	BEARING, ER-16	1
001009	BEARING, ER-24	3
001054	BEARING, ER-16X	8
008004	ROD END, 3/8" ID X 38-24 MALE	2
021004	SPRING, 5/8" X 4" LG (BLUE)	2
032004	SET COLLAR, 1/2" X 1"	2
050041	PIPE PLUG, 1/2" NPT	2
060033	BELT, 1/2"P X 1"W X 60" LG	1
061041	BUSHING, 20T X 1/2P X 1" W TYPE EF WITH TAPER BUSHING	1
061048	BELT, GEAR, 16T X 1/2P (SCP2)	1
062036	TAPER BUSHING, 1-1/2" 20 BORE	1
069001	RINGFEDER 38X44	4
069012	SHAFT, IDLER, 1" DIAMETER X 2-1/8"	1
069018	BRACKET, IDLER	1
613030	BRACKET, PREFORM ROLL	1
613050	SHAFT, MOVEABLE NIP ROLL	1
613160	CAP, NIP ROLL GEAR	1
613170	KNOB, NIP ROLL ADJUST	2
713250	BRACKET, GEAR SIDE PREFORM ROLL	1
713270	ROLLER, DROOP SNOT FORMER	4
713310	SHAFT	2
1613080	SPACER, PINCH ROLL	2
1613090	SPACER, PINCH ROLL	2
1613112	GEAR, NIP ROLL (RIGHT)	1
1613121	GEAR, NIP ROLL (LEFT)	1
1613131	CAP, NIP ROLL GEAR	1
1613141	NIP ROLL, ATLAS HALF-FOLD	3
1619280	PLATE, OPERATOR SIDE, NIP ROLL SWING, HALF-FOLD	1

ATLAS FOLDER

CONTINUED

OPTION: UPPER PREFORM & NIP ROLL 1619002A

PART NO.	DESCRIPTION	QTY. REQ'D
1619290	PLATE, GEAR SIDE, NIP ROLL SWING	1
1619320	SHAFT, DRIVEN NIP ROLL	1
1619330	ROD, NIP ROLL ADJUST	2
1619340	ROD, NIP ROLL ADJUST	2
1619350	WASHER	8
1619590	SHAFT	4
1619610	STIFFENER, BALLOON FORMER	2
1619651	FRAME, PULL ROLLER, OPERATOR SIDE	1
1619661	FRAME, PULL ROLLER, GEAR SIDE	1

ATLAS FOLDER
UPPER FORMER 1619003

PART NO.	DESCRIPTION	QTY. REQ'D
001001	BEARING, ER-16	2
001054	BEARING, ER-16X	28
021028	SPRING, 1" ID X 1" LG (BLUE)	3
032003	SET COLLAR, 1" X 1-5/8"	2
033001	KNOB, 1-3/8" OD X 3/8-16	1
033003	KNOB, 3-1/8" OD X 1/2-13	3
060039	BELT, 1/2"P X 1" W X 170" LG	1
061041	BUSHING, 20T X 1/2P X 1" W TYPE EF WITH TAPER BUSHING	2
061048	GEAR BELT, 16"T X 1/2"P (SCP2)	1
061076	PULLEY, WITH TAPER BUSHING 26H200	1
062015	TAPER BUSHING, 1" BORE	2
062019	TAPER BUSHING, SDS-1" BORE	1
067023	GEAR BOX, 1:1 RATIO, MODEL 11D 3A	1
067054	GEAR BOX MODEL II, STYLE C	1
068036	FLANGE, COMPANION	2
069004	SHAFT, IDLER, 1" DIAMETER X 3-1/8" SL3C	1
069011	SHAFT, IDLER, 1" DIAMETER X 4-1/8"	2
069013	PULLEY, IDLER, 4" DIAMETER X 1" HOLE	2
069018	BRACKET, IDLER	1
069020	PULLEY, IDLER	1
069022	TIGHTENER, FIXED FLANGE	2
090143	LATCH	2
090157	CATCH, FOR 090143 LATCH	2
511160	STIFFENER, UPPER	4
511480	STIFFENER, SHAFT	10
511490	ROLLER CORE	10
611150	HEAD ROLL	1
611230	BRACKET, TROLLEY CLAMP	3
611240	SHAFT, TROLLEY	1
611250	HANDLE, TROLLEY SHAFT	1

**ATLAS FOLDER
UPPER FORMER 1619003**

CONTINUED

PART NO.	DESCRIPTION	QTY. REQ'D
611271	BRACKET, TROLLEY PIVOT	3
611280	AXLE, TROLLEY	3
611290	SLITTER, ADJUSTING SCREW	3
611310	TROLLEY WHEEL	3
713101	FORMER ASSEMBLY	1
713170	MOUNTING, FORMER SHAFT	1
713180	MOUNTING, BOSS SHAFT	1
713190	SCREW, FORMER MOUNTING	2
713210	SHAFT, FORMER ADJUST	1
713270	ROLLER, DROOP SNOOT FORMER	4
1527160	SPACER, LATCH	2
1619011	BASE FRAME, OPERATOR SIDE	1
1619021	BASE FRAME, GEAR SIDE	1
1619240	SUPPORT	2
1619250	SHAFT, IDLER ROLL	2
1619260	ROD, THREADED	4
1619271	MOUNTING PLATE, GEAR BOX	1
1619310	STIFFENER, HEAD ROLL STAND	5
1619512	GUARD, LOWER NIPS	1
1619582	DRIVE SHAFT, BALLOON FORMER	1
1619600	EXTENSION, BASE FRAME	2
1619680	SHAFT	2
1619711	HEADROLL FRAME, OPERATOR SIDE	1
1619721	HEADROLL FRAME, GEAR SIDE	1
1619820*	GUARD	1
1619842	GUARD	1
1619862	GUARD, DOOR	1
1619891	GUARD, UPPER NIPS	1
1619901	GUARD, UPPER NIPS	1

*Note: Replaces 1612161 Guard, Parts List 2619001

ATLAS FOLDER
UPPER FORMER 1619003

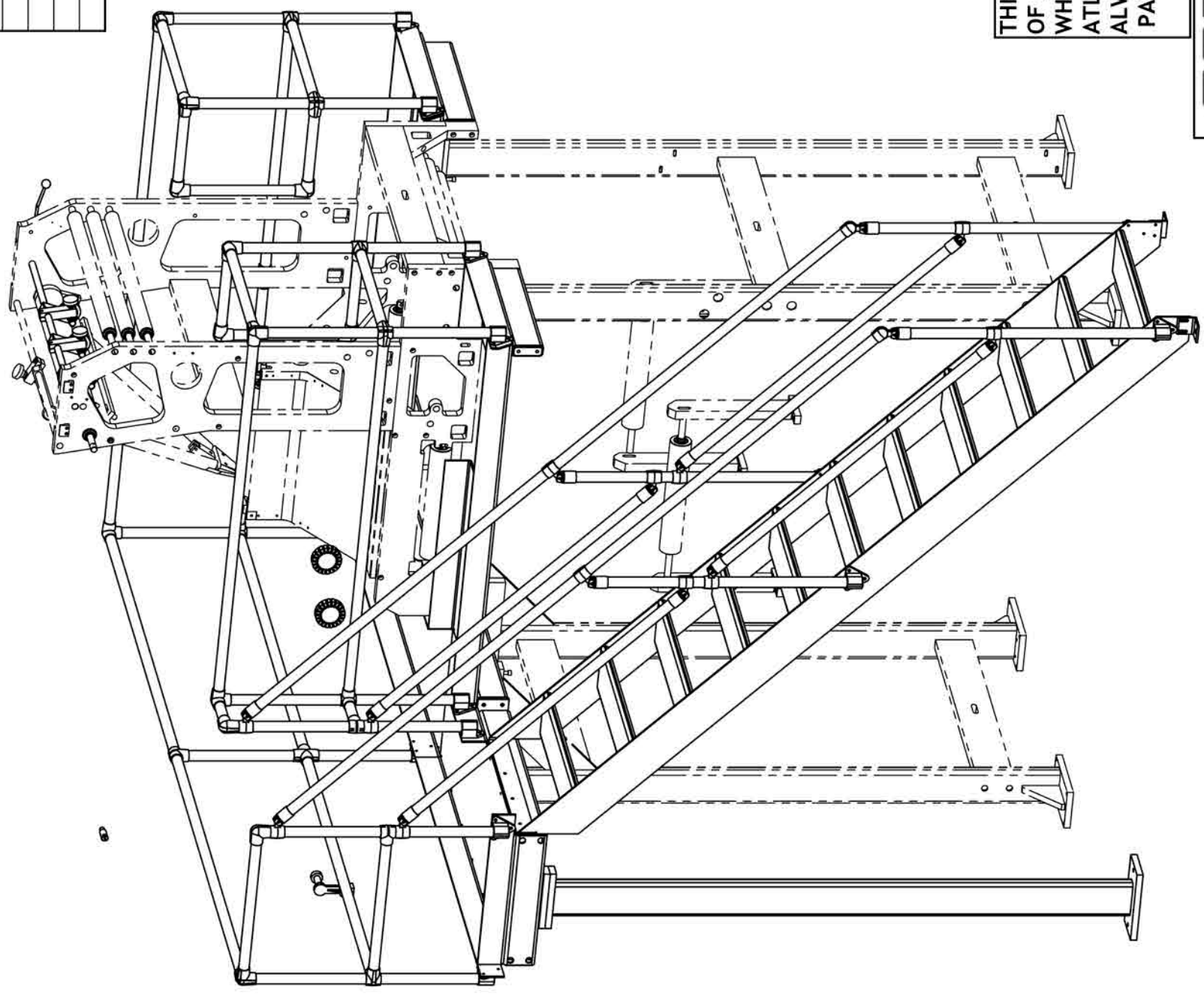
CONTINUED

PART NO.	DESCRIPTION	QTY. REQ'D
1620200	LEG, FRONT RIGHT SUPPORT	1
1620210	LEG, FRONT LEFT SUPPORT	1
1620270	BRACE, CROSSED	2
1620300	LEG, FRONT RIGHT	1
1620310	LEG, FRONT LEFT	1
1620320	STIFFENER, HEADROLL PLATE	1
1620600	DRIVE, UPPER FORMER HEADROLL	1
1620710	PAPER STAND	4
1691560	PULLEY, HEAD ROLL DRIVE	1
1713140	BRACKET, FORMER BOARD MOUNT	2
1713150	SLEEVE, FORMERBOARD CENTERING	2
2619120	RETAINER	2

ATLAS FOLDER
OPTION: UPPER FORMER WALKWAY ASSEMBLY –SINGLE LINE
1619003C

090721	STAIRWAY, GALVANIZED	1
1620330	LEG, SUPPORT	1
1620430	PLATE, MOUNT	1
1620360	BRACE, PLATFORM 1	1
090094	PIPE, ALUMINUM, 1-1/4" X 1.660"	200 FT
090100	FLANGE, #50, 1-1/4" DIAMETER	13
090719	ELBOW, ADJUST, #3AE X 1-1/4"	2
090088	"ELL" #3, 1-1/4", BALLOON FORMER	6
090089	FITTING, SOLID "T", #5, 1-1/4"	4
090090	CROSS, #7, 1-1/4"	2
090091	OUTLET, SIDE, #9, 1-1/4"	7
090092	OUTLET, SIDE, #11, 1-1/4"	7
1620390	BRACE, PLATFORM 2	1
1620440	BRACE, PLATFORM 3	1
1620460	BRACE, PLATFORM 4	2
1620480	BRACE, PLATFORM 5	3
1620490	DECK PLATE 1	1
1620500	DECK PLATE ASSEMBLY 2	1
1620530	DECK PLATE ASSEMBLY 3	1
1620550	DECK PLATE ASSEMBLY 4	1
1620610	SPEED RAIL, LEFT, #50 X 1-1/4"	1
1620620	SPEED RAIL, RIGHT, #50 X 1-1/4"	1

DATE	SYM	REVISION/RECORD	DR	CK
4/29/05	A	NEW RELEASE	GV	



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WEB PRESS LLC
701 EAST D ST., TACOMA, WA 98002

TITLE WALKWAY, SINGLE LINE

SIZE	DWG. NO.	
B	1619003C	
SCALE	DATE	SHEET
1:24	4/29/05	1 OF 7
APPROVALS		REV.
GV		A

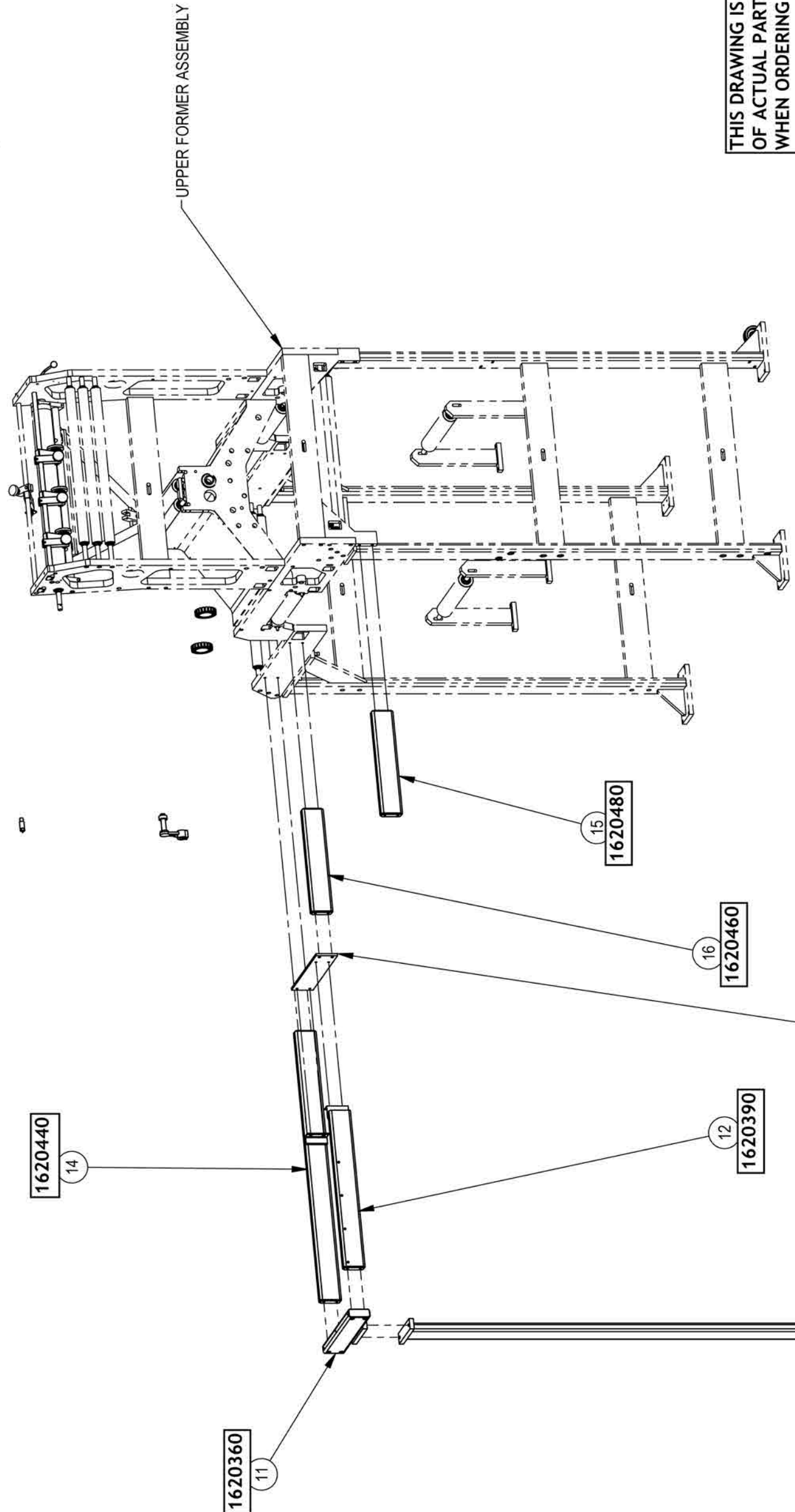
TOLERANCES (EXCEPT AS SHOWN)	
FRACTIONAL	± 1/32
DECIMALS	.XX ± .01 .XXX ± .005
ANGLES	± 1°
DO NOT SCALE DRAWING	

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ITEM NO.	PART NO.	DESCRIPTION	QTY.
1	090088	#3 X 1 1/4 ELL, SPEED RAIL	6
2	090089	#5 X 1 1/4 SIDE OUTLET TEE, SPEED RAIL	4
3	090090	#7 X 1 1/4 ELL, SPEED RAIL	2
4	090091	#9 X 1 1/4 SIDE OUTLET TEE, SPEED RAIL	7
5	090092	#11 X 1 1/4 SIDE OUTLET TEE, SPEED RAIL	7
6	090100	#50 X 1 1/4 SPEED RAIL	13
7	090103	#17 ADJUSTABLE ELBOW	12
8	090719	ADJUSTABLE ELL	2
9	090721	STAIRWAY	1
10	1620330	SUPPORT LEG	1
11	1620360	PLATFORM BRACE 1	1
12	1620390	PLATFORM BRACE 2	1
13	1620430	MOUNT PLATE	1
14	1620440	PLATFORM BRACE 3	1
15	1620480	PLATFORM BRACE 5	3
16	1620460	PLATFORM BRACE 4	2
17	1620490	DECK PLATE 1	1
18	1620500	DECK PLATE ASSY 2	1
19	1620530	DECK PLATE ASSY 3	1
20	1620550	DECK PLATE ASSY 4	1
21	1620610	#50 X 1 1/4 SPEED RAIL LEFT	1
22	1620620	#50 X 1 1/4 SPEED RAIL RIGHT	1
23	090094	1 1/4" ID X 1.660 OD ALUM. PIPE (HANDRAIL)	165'

DATE	SYM	REVISION/RECORD	DR	CK
4/29/05	A	NEW RELEASE	GV	



THIS DRAWING IS REPRESENTATIVE FOR IDENTIFICATION OF ACTUAL PARTS ONLY AND IS INCLUDED AS REFERENCE WHEN ORDERING REPLACEMENT PARTS FOR THE ATLAS 22-3/4" FOLDER. ALWAYS REFER TO THE PART NUMBERS WHEN ORDERING PARTS, INCLUDING THE SERIAL NUMBER OF THE FOLDER.

WEB PRESS LLC
701 EAST D ST., TACOMA, WA 98002

TITLE: **WALKWAY, SINGLE LINE**

DRAWN: **G VARGAS** SIZE: **B** DWG. NO: **1619003C**
 APPROVALS: **GV** SCALE: **1:28** DATE: **4/29/05** SHEET **2** OF **7** REV. **A**

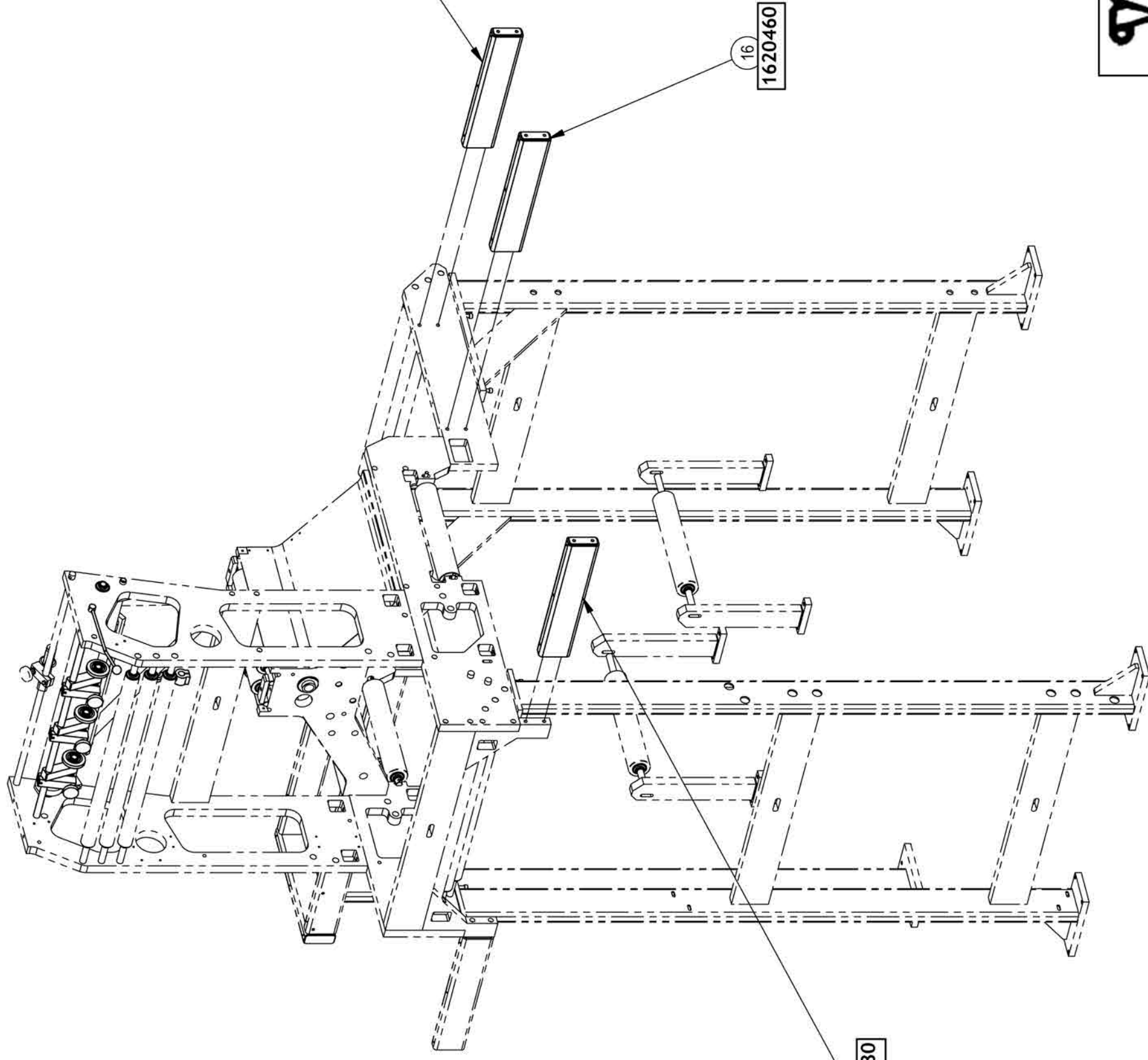
TOLERANCES (EXCEPT AS SHOWN)	
FRACTIONAL	± 1/32
DECIMALS	.XX ± .01 .XXX ± .005
ANGLES	± 1°

DO NOT SCALE DRAWING

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 UNIFORM TITLE - SEC 1.1 (RCW 19.108)

Grid lines are labeled with letters A, B, C, D and numbers 1 through 8 along the bottom and left edges of the drawing area.

DATE	SYM	REVISION/RECORD	DR	CK
4/29/05	A	NEW RELEASE	GV	



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701 EAST D ST., TACOMA, WA 98002

WALKWAY, SINGLE LINE

SIZE: B
SCALE: 1:20
DATE: 4/29/05
SHEET 3 OF 7

DRAWN: G VARGAS
MODELER: GV
APPROVALS: GV

TOLERANCES (EXCEPT AS SHOWN)	
FRACTIONAL	$\pm 1/32$
DECIMALS	.XX $\pm .01$.XXX $\pm .005$
ANGLES	$\pm 1^\circ$

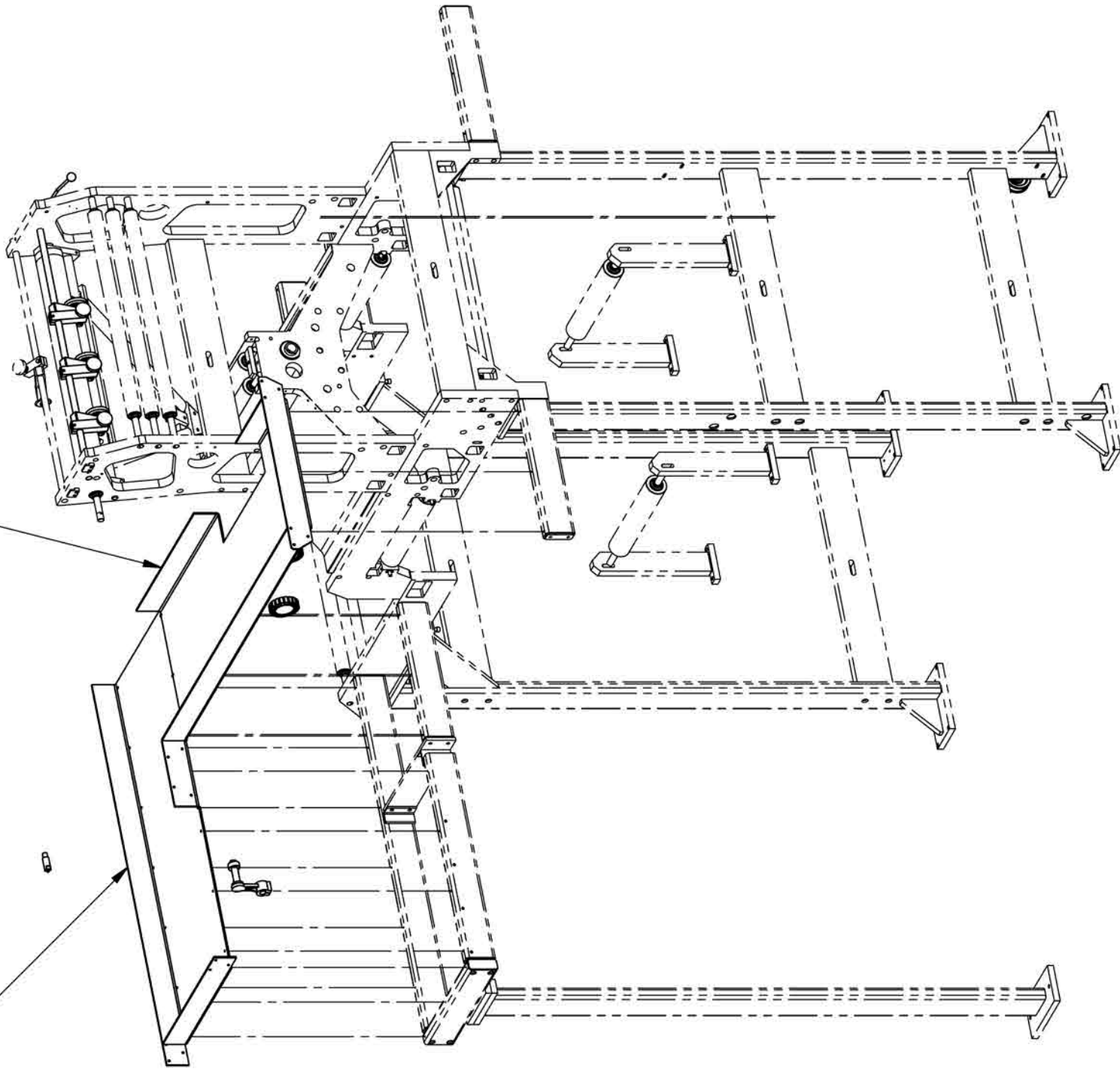
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D C B A 2 3 4 5 6 7 8

DATE	SYM	REVISION/RECORD	DR	CK
4/29/05	A	NEW RELEASE	GV	



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WEB PRESS LLC
701 EAST D ST., TACOMA, WA 98002

WALKWAY, SINGLE LINE

SIZE: B
DWG. NO: 1619003C
SCALE: 1:24
DATE: 4/29/05
SHEET 4 OF 7
REV. A

APPROVALS: GV

TOLERANCES (EXCEPT AS SHOWN)

FRACTIONAL	± 1/32
DECIMALS	.XX ± .01 .XXX ± .005
ANGLES	± 1°

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DATE	SYM	REVISION/RECORD	DR	CK
4/29/05	A	NEW RELEASE	GV	

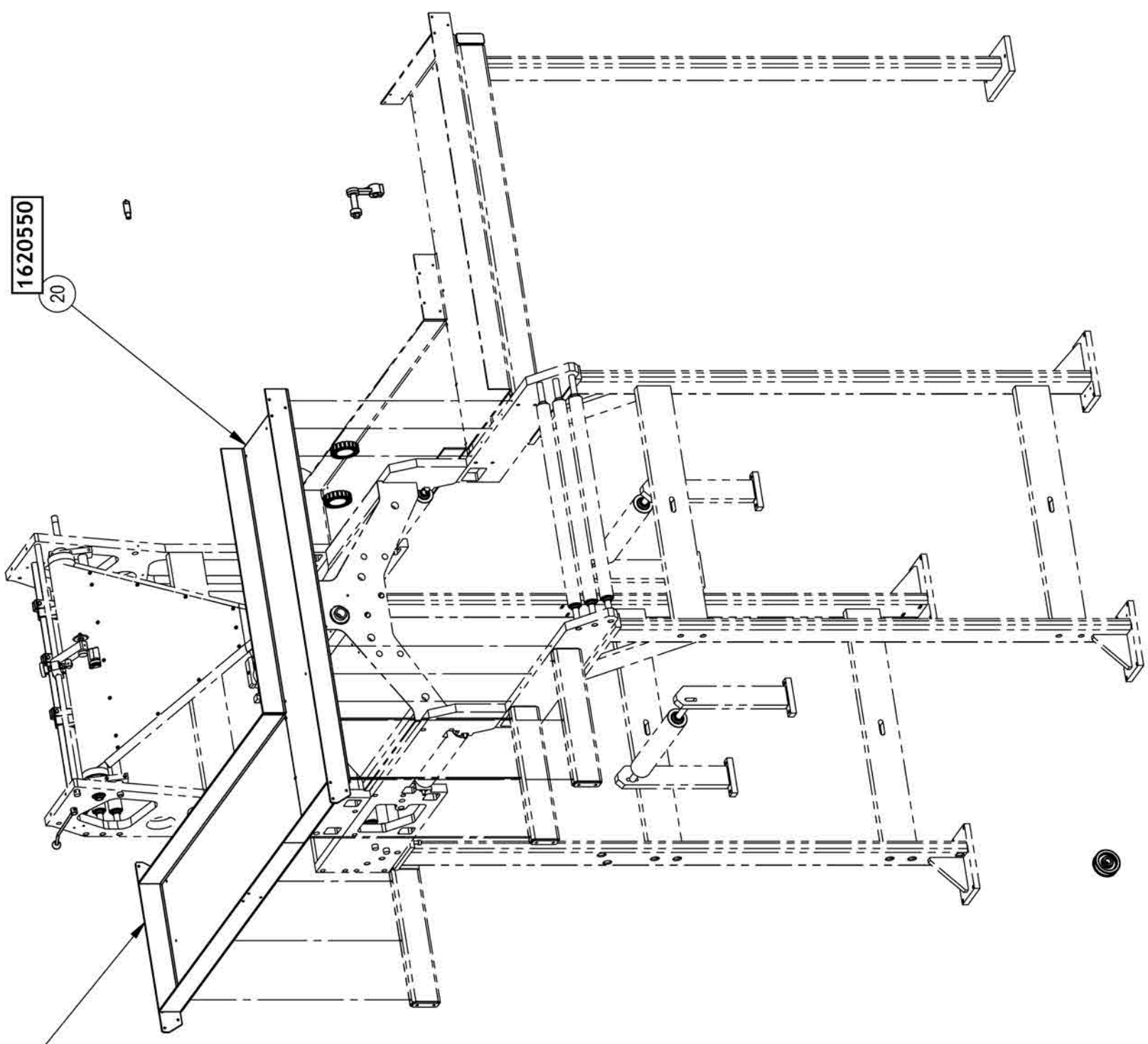
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WEB PRESS LLC
701 EAST D ST., TACOMA, WA 98002

WALKWAY, SINGLE LINE

SIZE: B DWG. NO: 1619003C
SCALE: 1:24 DATE: 4/29/05 SHEET 5 OF 7 REV. A

DRAWN: G VARGAS
APPROVALS: GV



TOLERANCES (EXCEPT AS SHOWN)

FRACTIONAL	± 1/32
DECIMALS	.XX ± .01 .XXX ± .005
ANGLES	± 1°

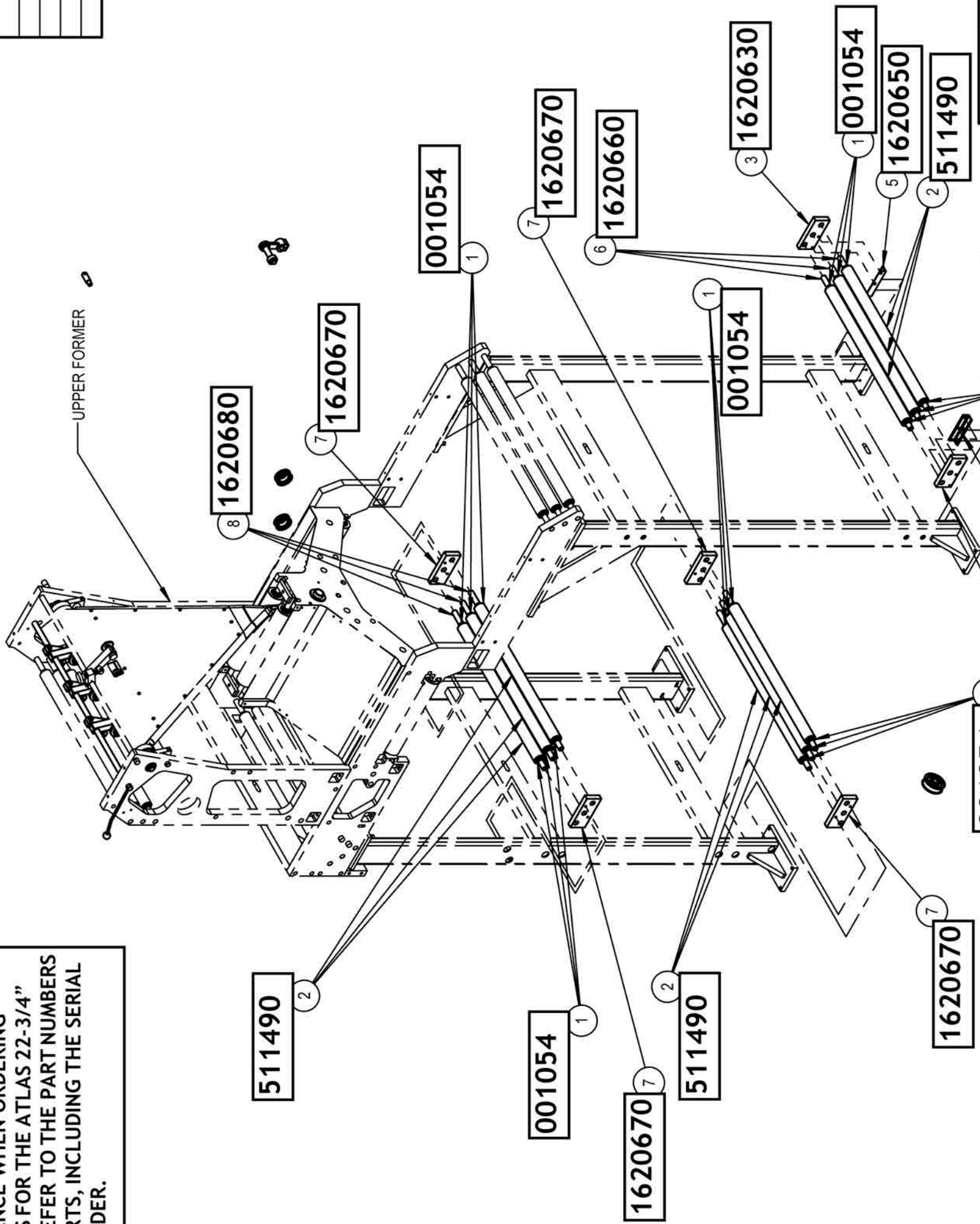
DO NOT SCALE DRAWING

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D C B A 7 6 5 4 3 2 1 8

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DATE	SYM	REVISION RECORD	DR	CK
5/6/05	A	NEW RELEASE	GV	

E:\S\CHD\WCRS\ATLAS

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UPPER FORMER UNDER FOLDER LEAD

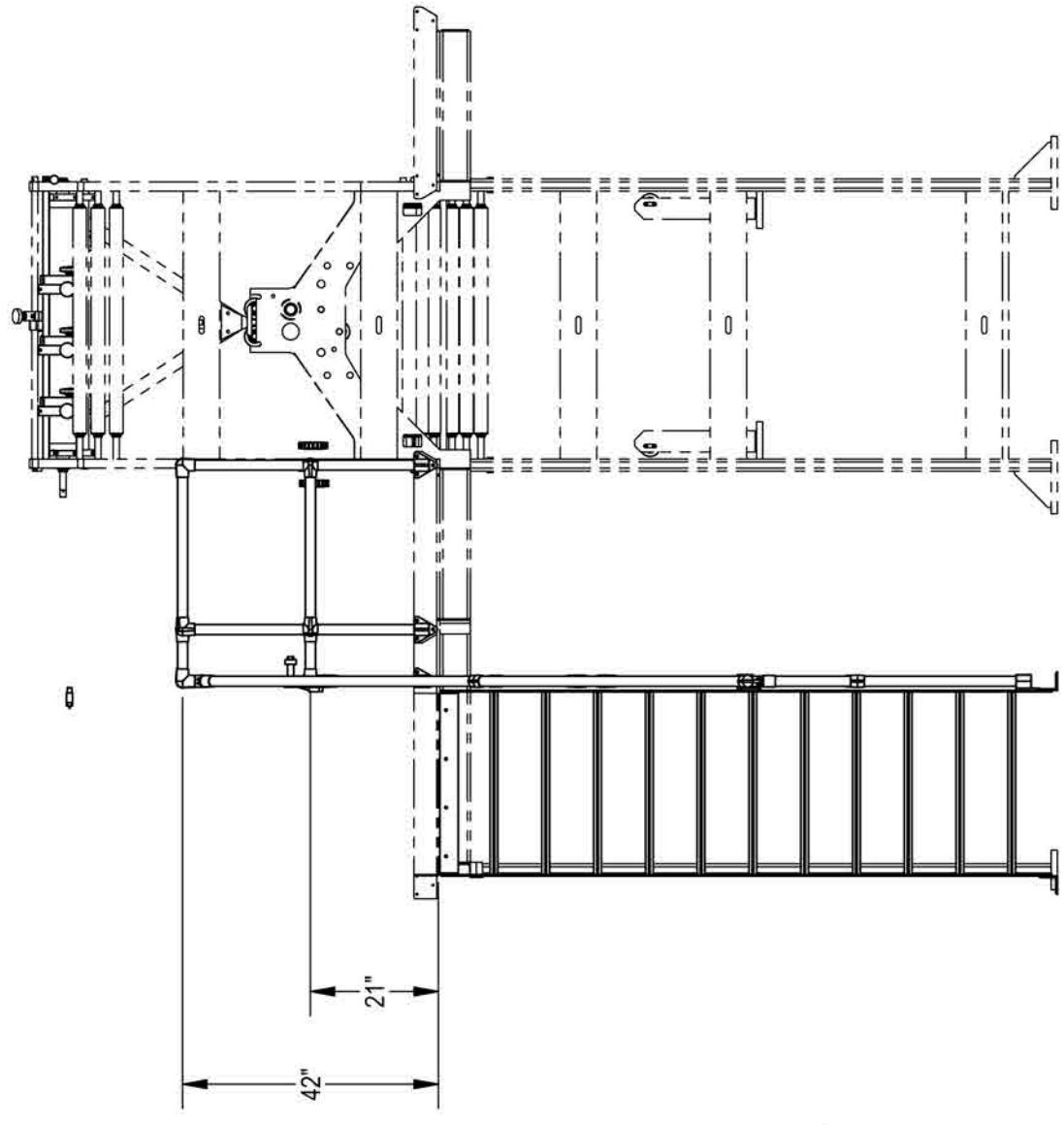
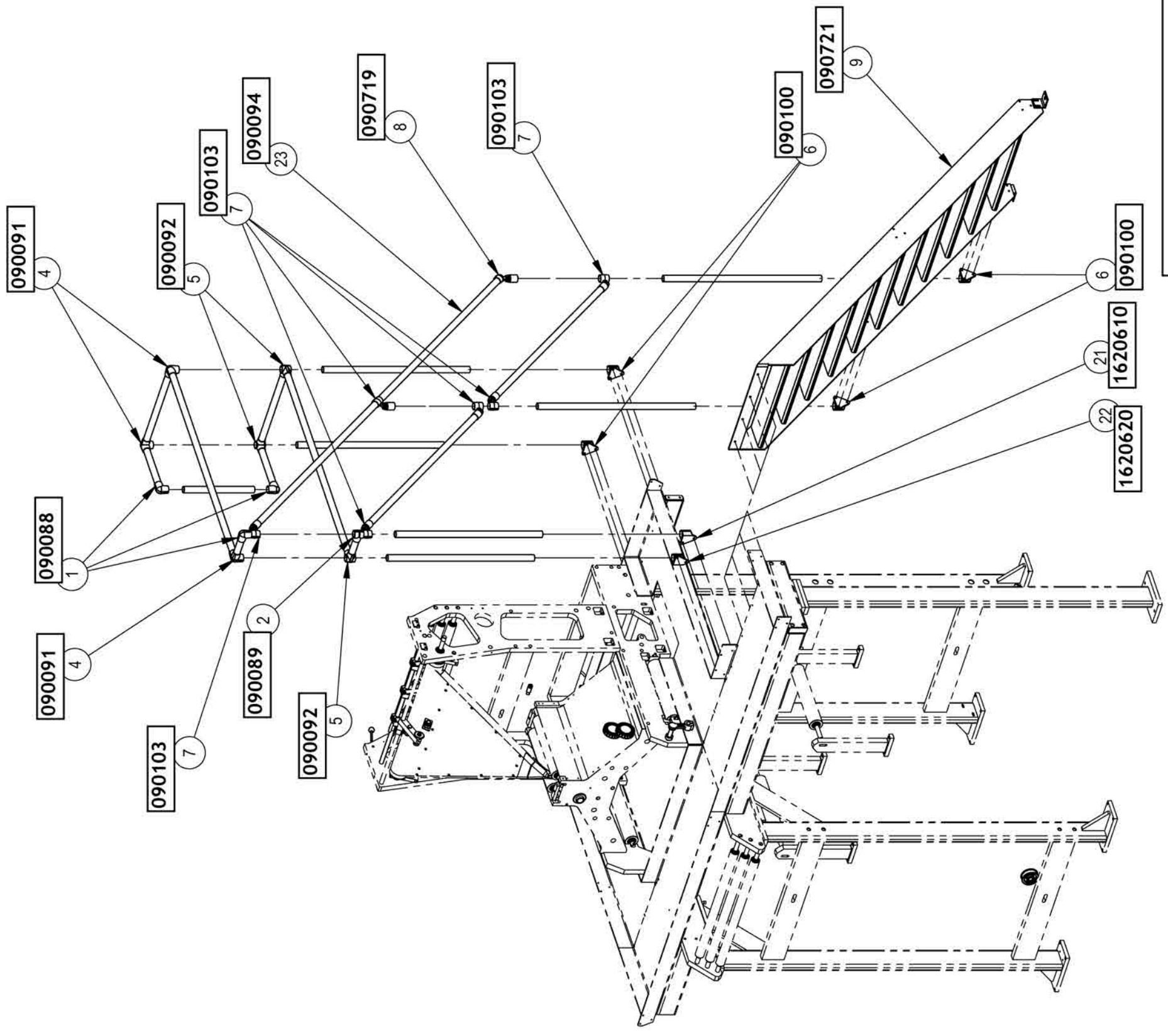
SIZE: B
DRAWN: G VARGAS
DWG. NO.: 1619003G

SCALE: 1:24
DATE: 5/6/05
SHEET: 2 OF 2
REV: A

APPROVALS: GV

TOLERANCES (EXCEPT AS SHOWN)
FRACTIONAL: ±1/32
DECIMALS: .XX ± .01
ANGLES: .XXX ± .005
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DATE	SYM	REVISION/RECORD	DR	CK
4/29/05	A	NEW RELEASE	GV	



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TITLE WALKWAY, SINGLE LINE

DRAWN: G VARGAS
SCALE: 1:32
DATE: 4/29/05
REV. 6

APPROVED: GV
MODEL/DWG. NO. B
1619003C

REV. 7

TOLERANCES (EXCEPT AS SHOWN)

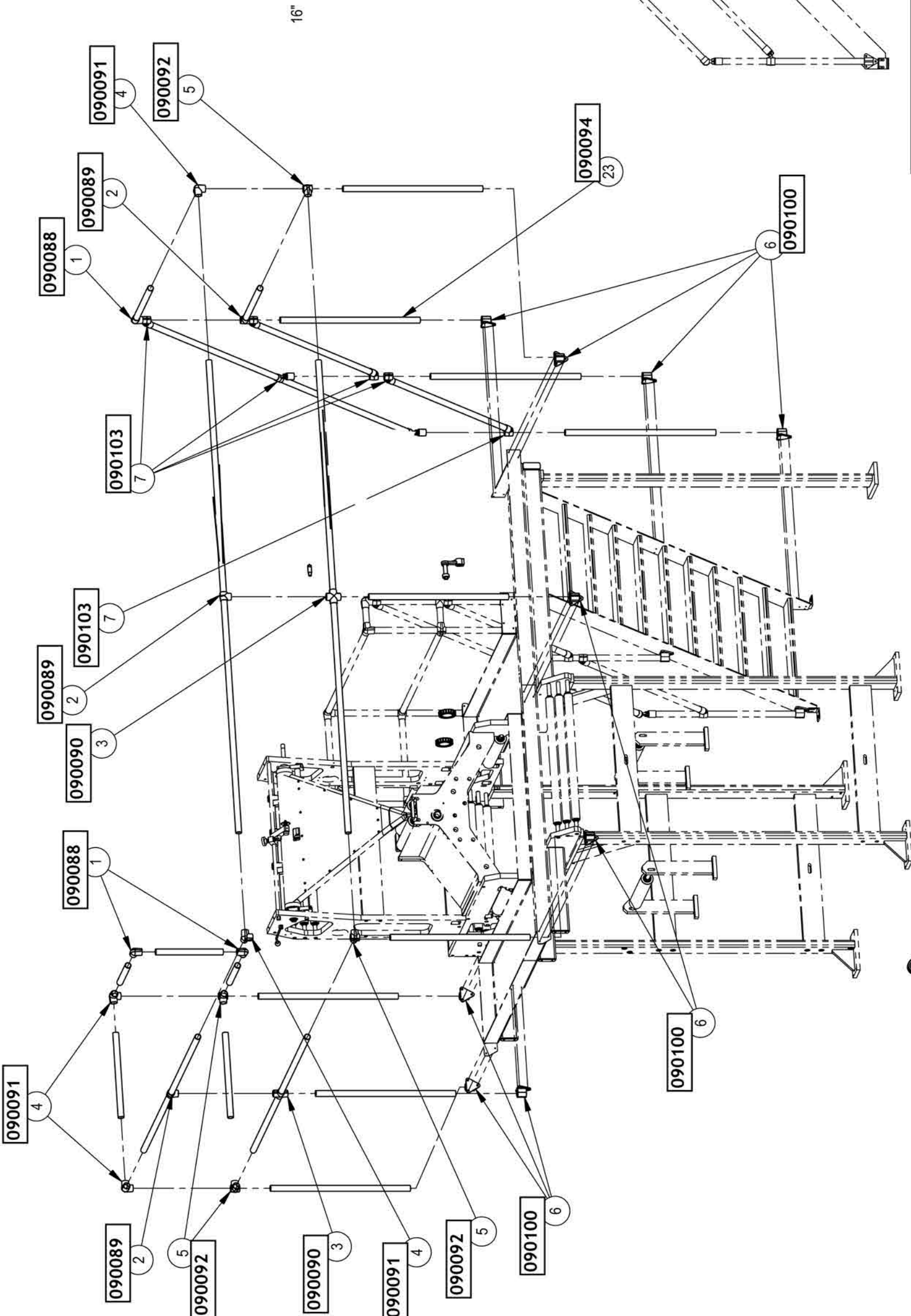
FRACTIONAL	±1/32
DECIMALS	.XX ±.01
ANGLES	.XXX ±.005

DO NOT SCALE DRAWING

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DATE	SYM	REVISION/RECORD	DR	CK
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701 EAST D ST., TACOMA, WA 98002

WALKWAY, SINGLE LINE

SIZE: B
SCALE: 1:32
DATE: 4/29/05
SHEET 7 OF 7

DRAWN: G VARGAS
APPROVALS: GV

TOLERANCES (EXCEPT AS SHOWN)	
FRACTIONAL	± 1/32
DECIMALS	.XX ± .01 .XXX ± .005
ANGLES	± 1°
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ATLAS FOLDER

OPTION: UPPER FORMER OVER FOLDER LEAD 1619003F

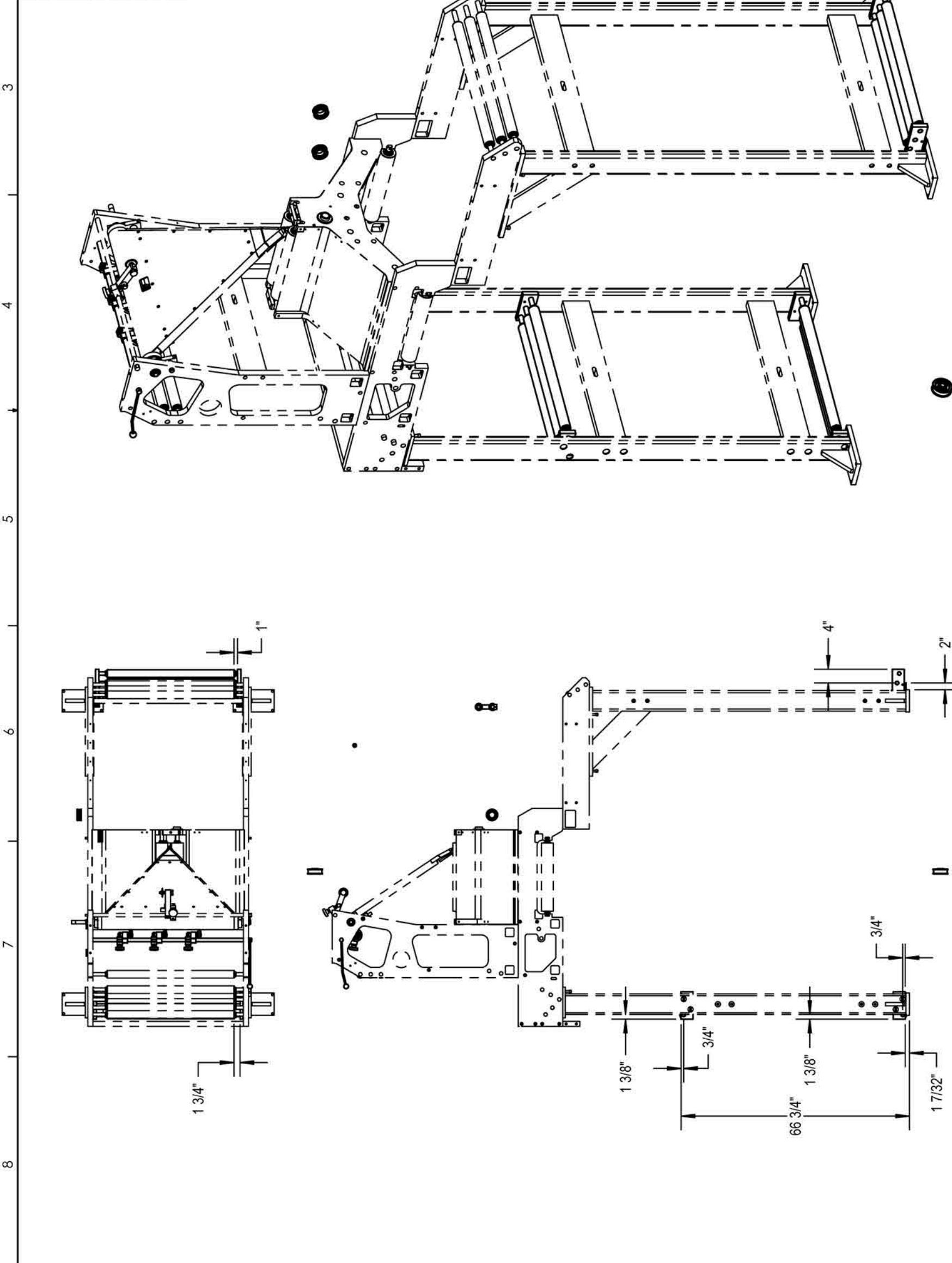
PART NO.	DESCRIPTION	QTY. REQ'D
001054	BEARING, ER-16X	12
1620580	BRACKET, ARM	2
1620590	MOUNT, OVER FOLDER LEAD	2
2737050	STIFFENER, SHAFT	2
511480	STIFFENER, SHAFT	6
511490	ROLLER CORE	6

ATLAS FOLDER

OPTION: UPPER FORMER UNDER FOLDER LEAD 1619003G

001054	BEARING, ER-16X	18
511490	ROLLER CORE	9
1620630	BRACKET, ROLLER -A	2
1620640	MOUNT, ANGLE -A	1
1620650	MOUNT, ANGLE -B	1
1620660	SHAFT, ROLLER - A	3
1620670	PLATE	4
1620680	SHAFT, ROLLER - B	6

DATE	SYM	REVISION RECORD	DR	CK
5/6/05	A	NEW RELEASE	GV	



NOTES:

1. IDLER ROLLER LOCATIONS ARE USED FOR A STARTING POINT ONLY, ADJUSTMENTS MAY BE NECESSARY TO MAKE WEB TRACK AND CENTER PROPERLY.

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UPPER FORMER UNDER FOLDER LEAD

DRAWN: **G VARGAS** SIZE: **B** DWG. NO.: **1619003G**

APPROVALS: **GV** SCALE: **1:32** DATE: **5/6/05** SHEET **1** OF **2** REV. **A**

TOLERANCES (EXCEPT AS SHOWN)

FRACTIONAL	± 1/32
DECIMALS	.XX ± .01 .XXX ± .005
ANGLES	± 1°

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ITEM NO.	PART NO.	DESCRIPTION	QTY.
1	001054	ER - 16X BEARING	18
2	511490	ROLLER CORE	9
3	1620630	ROLLER BRACKET A	2
4	1620640	MOUNT ANGLE A	1
5	1620650	MOUNT ANGLE B	1
6	1620660	ROLLER SHAFT A	3
7	1620670	PLATE	4
8	1620680	ROLLER SHAFT B	6

